



MODEL G0568/G0569 24" INDUSTRIAL BANDSAW OWNER'S MANUAL



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(FOR MODELS MANUFACTURED SINCE 10/04) CA6450# PRINTED IN TAIWAN



WARNING!

This manual provides critical safety instructions on the proper setup, operation, maintenance and service of this machine/equipment.

Failure to read, understand and follow the instructions given in this manual may result in serious personal injury, including amputation, electrocution or death.

The owner of this machine/equipment is solely responsible for its safe use. This responsibility includes but is not limited to proper installation in a safe environment, personnel training and usage authorization, proper inspection and maintenance, manual availability and comprehension, application of safety devices, blade/cutter integrity, and the usage of personal protective equipment.

The manufacturer will not be held liable for injury or property damage from negligence, improper training, machine modifications or misuse.



WARNING!

Some dust created by power sanding, sawing, grinding, drilling, and other construction activities contains chemicals known to the State of California to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:

- **Lead from lead-based paints.**
- **Crystalline silica from bricks, cement and other masonry products.**
- **Arsenic and chromium from chemically-treated lumber.**

Your risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals: Work in a well ventilated area, and work with approved safety equipment, such as those dust masks that are specially designed to filter out microscopic particles.

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INTRODUCTION

Manual Accuracy

We are proud to offer this manual with your new machine! We've made every effort to be exact with the instructions, specifications, drawings, and photographs of the machine we used when writing this manual. However, sometimes errors do happen and we apologize for them.

Also, owing to our policy of continuous improvement, **your machine may not exactly match the manual**. If you find this to be the case, and the difference between the manual and machine leaves you in doubt, check our website for the latest manual update or call technical support for help.

Before calling, find the manufacture date of your machine by looking at the date stamped into the machine ID label (see below). This will help us determine if the manual version you received matches the manufacture date of your machine.

		MODEL GXXXX	
		MACHINE NAME	
SPECIFICATIONS		⚠ WARNING!	
Motor:		Manufacture Date of Your Machine When using this machine: operation, is and respirator. sted/setup and built before starting. 4. make sure the motor has stopped and disconnect power before adjustments, maintenance, or service. 5. DO NOT expose to rain or dampness. 6. DO NOT modify this machine in any way. 7. DO NOT remove safety guards. 8. Never leave machine running unattended. 9. DO NOT operate under the influence of drugs or alcohol. 10. Maintain machine carefully to prevent accidents.	
Specification:			
Specification:			
Specification:			
Weight:			
	Date		
	Serial Number		
Manufactured for Grizzly in Taiwan			

For your convenience, we post all available manuals and manual updates for free on our website at **www.grizzly.com**. Any updates to your model of machine will be reflected in these documents as soon as they are complete.

Contact Info

We stand behind our machines. If you have any service questions, parts requests or general questions about the machine, please call or write us at the location listed below.

Grizzly Industrial, Inc.
1203 Lycoming Mall Circle
Muncy, PA 17756
Phone: (570) 546-9663
Fax: (800) 438-5901
E-Mail: techsupport@grizzly.com

If you have any comments regarding this manual, please write to us at the address below:

Grizzly Industrial, Inc.
c/o Technical Documentation Manager
P.O. Box 2069
Bellingham, WA 98227-2069
Email: manuals@grizzly.com

Machine Description

The bandsaw is a versatile cutting tool that can be used to perform a wide variety of cuts in wood workpieces.

The bandsaw features a flexible steel band with teeth on one edge that fits around two wheels, which rotate during operation to drive the blade.

When a workpiece is pushed against the moving blade, the downward force of the blade teeth scrape across the workpiece and, in effect, cut it. Blade guides on both sides of the cutting area keep the blade from flexing or being pushed off the wheels from the horizontal pressure of the workpiece while cutting.



Identification

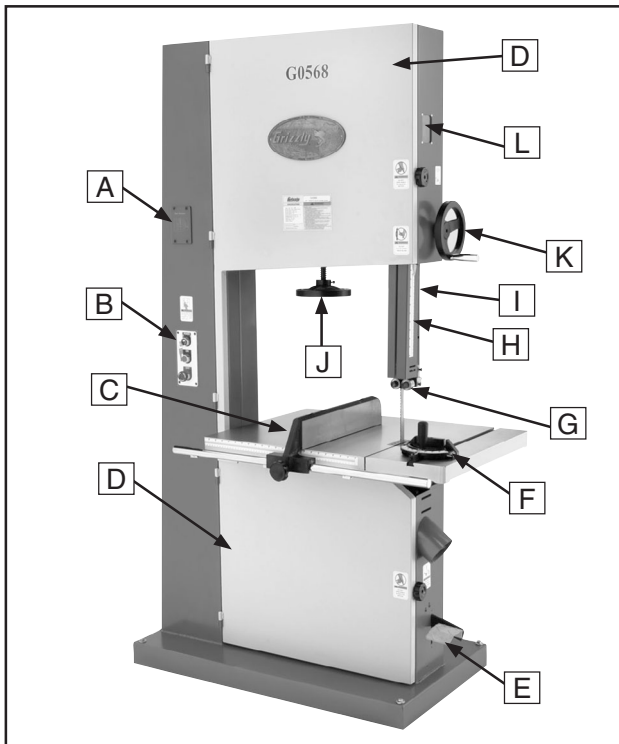


Figure 1. G0568 front view.

- A. Blade Tension Indicator
- B. Key Switch, Start & Stop Buttons
- C. Rip Fence
- D. Hinged Wheel Covers
- E. Foot Brake
- F. Miter Gauge
- G. Ball Bearing Blade Guides
- H. Cutting Height Scale
- I. Guide Post
- J. Blade Tension Handwheel
- K. Guide Post Handwheel
- L. Blade Tracking Window

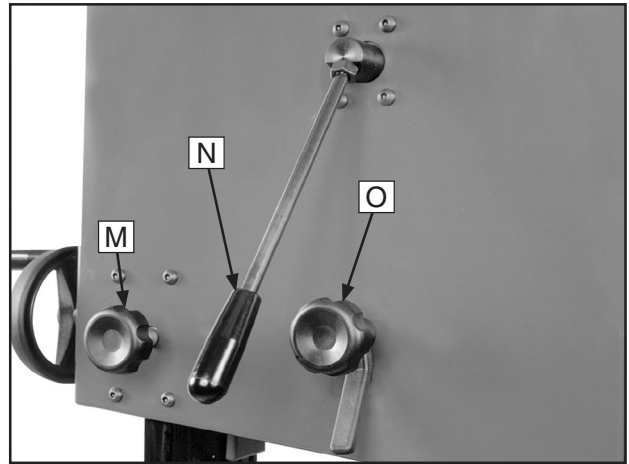


Figure 2. G0568 rear, top-side of the bandsaw.

- M. Guide Post Lock Knob
- N. Blade Tension Lever
- O. Blade Tracking Knob

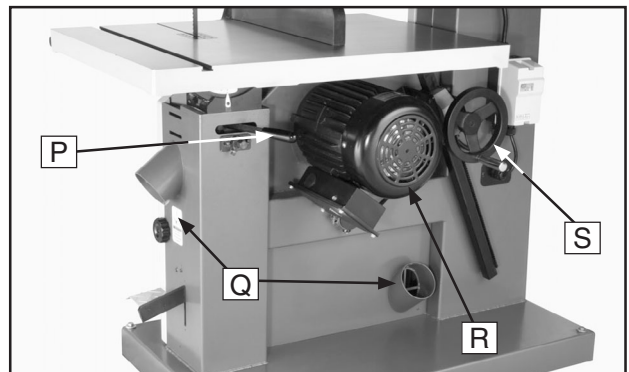
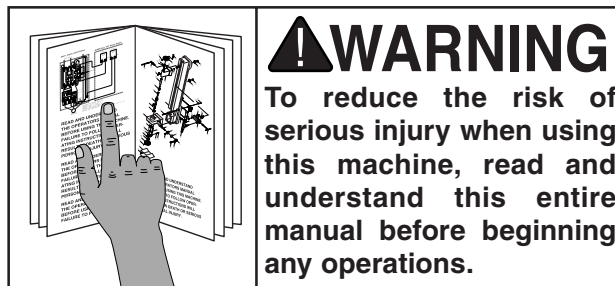


Figure 3. G0568 rear, lower-side of the bandsaw.

- P. Table Tilt Lock Lever
- Q. 4" Dust Ports
- R. Motor
- S. Table Tilt Handwheel





MACHINE DATA SHEET

Customer Service #: (570) 546-9663 · To Order Call: (800) 523-4777 · Fax #: (800) 438-5901

MODEL G0568 24" INDUSTRIAL BANDSAW 5 HP SINGLE-PHASE

Product Dimensions:

Weight..... 836 lbs.
Length/Width/Height..... 47-5/8 x 31-1/4 x 83-1/2 in.
Foot Print (Length/Width)..... 41-3/8 x 23-1/2 in.

Shipping Dimensions:

Type..... Wood Slat Crate
Content..... Machine
Weight..... 959 lbs.
Length/Width/Height..... 46 x 28 x 87 in.

Electrical:

Switch..... Magnetic with Thermal Overload Protection
Switch Voltage..... 220V
Cord Gauge..... 8 gauge
Minimum Circuit Size..... 40 amp
Plug Included..... No

Motors:

Main

Type..... TEFC Capacitor Start Induction
Horsepower..... 5 HP
Voltage..... 220V
Prewired..... 220V
Phase..... Single
Amps..... 30A
Speed..... 1725 RPM
Cycle..... 60 Hz
Number Of Speeds..... 1
Power Transfer V-Belt
Bearings..... Shielded and Permanently Lubricated

Main Specifications:

Operation

Blade Speeds..... 5300 FPM
Table Tilt..... Right 45 deg.

Cutting Capacities

Maximum Cutting Height..... 16-1/4 in.
Max Capacity Under Handwheel..... 16-1/4 in.
Max Capacity Left of Blade..... 24-1/2 in.



Blade Information

Standard Blade Length.....	181 in.
Blade Length Range.....	180 - 181-1/2 in.
Blade Width Range.....	1/4 - 1-1/2 in.
Upper Blade Guides.....	Ball Bearing
Lower Blade Guides.....	Ball Bearing
Guide Post Size.....	1.180 in. (30mm)
Guide Post Type.....	Sq. Solid Steel

Table Information

Table Length.....	23-5/8 in.
Table Width.....	33-1/2 in.
Table Thickness.....	2 in.
Floor to Table Height.....	34-1/2 in.

Fence Information

Locks in Front.....	Yes
Locks in Rear.....	No
Adjustable for Blade Lead.....	No

Construction

Table Construction.....	Precision Ground Cast Iron
Rip Fence	Precision Ground Cast Iron
Base Construction.....	Steel
Body Construction.....	Pre-Formed Steel
Upper Wheel.....	Computer Balanced Cast Iron
Lower Wheel.....	Computer Balanced Cast Iron
Tire Material.....	Rubber
Wheel Cover	Pre-Formed Steel
Paint.....	Powder Coated

Other Related Information

Wheel Diameter.....	24-3/4 in.
Wheel Width.....	1-3/4 in.
Number of Dust Ports.....	2
Dust Port Size.....	4 in.
Mobile Base.....	G7315, G8685

Other Specifications:

ISO Factory	ISO 9001
Country Of Origin	Taiwan
Warranty	1 Year
Serial Number Location	ID Label
Assembly Time	30 minutes

Features:

- Quick Change Blade Release/Tensioner
- Blade Tension Indicator
- Micro Adjusting Rack and Pinion Table Tilt
- Height Scale Measurement
- Foot Brake Stop
- Included Miter Gauge
- Rack and Pinion Upper Guide Adjustment
- Magnifying Window Over Fence Scale
- Hinged Wheel Covers with Safety Lock





MACHINE DATA SHEET

Customer Service #: (570) 546-9663 · To Order Call: (800) 523-4777 · Fax #: (800) 438-5901

MODEL G0569 24" INDUSTRIAL BANDSAW 7-1/2 HP 3-PHASE

Product Dimensions:

Weight..... 836 lbs.
Length/Width/Height..... 31-1/4 x 47-5/8 x 83-1/2 in.
Foot Print (Length/Width)..... 41-3/8 x 23-1/2 in.

Shipping Dimensions:

Type..... Wood Slat Crate
Content..... Machine
Weight..... 962 lbs.
Length/Width/Height..... 45 x 28 x 87 in.

Electrical:

Switch..... Magnetic with Thermal Overload Protection
Switch Voltage..... 220V
Cord Gauge..... 12 gauge
Minimum Circuit Size..... 35 amp
Plug Included..... No
Conversion To 440V..... G8295
Phase Converter..... H3473

Motors:

Main

Type..... TEFC Induction
Horsepower..... 7-1/2 HP
Voltage..... 220/440V
Prewired..... 220V
Phase..... Three
Amps..... 20/10A
Speed..... 1725 RPM
Cycle..... 60 Hz
Number Of Speeds..... 1
Power Transfer V-Belt
Bearings..... Shielded and Permanently Lubricated

Main Specifications:

Operation

Blade Speeds..... 5300 FPM
Table Tilt..... Right 45 deg.

Cutting Capacities

Maximum Cutting Height..... 16-1/4 in.
Max Capacity Under Handwheel..... 16-1/4 in.
Max Capacity Left of Blade..... 24-1/2 in.



Blade Information

Standard Blade Length.....	181 in.
Blade Length Range.....	180 - 181-1/2 in.
Blade Width Range.....	1/4 - 1-1/2 in.
Upper Blade Guides.....	Ball Bearing
Lower Blade Guides.....	Ball Bearing
Guide Post Size.....	1.180 in. (30mm)
Guide Post Type.....	Sq. Solid Steel

Table Information

Table Length.....	23-5/8 in.
Table Width.....	33-1/2 in.
Table Thickness.....	2 in.
Floor to Table Height.....	34-1/2 in.

Fence Information

Locks in Front.....	Yes
Locks in Rear.....	No
Adjustable for Blade Lead.....	No

Construction

Table Construction.....	Precision Ground Cast Iron
Rip Fence	Precision Ground Cast Iron
Base Construction.....	Steel
Body Construction.....	Pre-Formed Steel
Upper Wheel.....	Computer Balanced Cast Iron
Lower Wheel.....	Computer Balanced Cast Iron
Tire Material.....	Rubber
Wheel Cover	Pre-Formed Steel
Paint.....	Powder Coated

Other Related Information

Wheel Diameter.....	24-3/4 in.
Wheel Width.....	1-3/4 in.
Number of Dust Ports.....	2
Dust Port Size.....	4 in.
Mobile Base.....	G7315, G8685

Other Specifications:

ISO Factory	ISO 9001
Country Of Origin	Taiwan
Warranty	1 Year
Serial Number Location	ID Label
Assembly Time	30 minutes

Features:

Quick Change Blade Release/Tensioner
Blade Tension Indicator
Micro Adjusting Rack and Pinion Table Tilt
Height Scale Measurement
Foot Brake Stop
Included Miter Gauge
Rack and Pinion Upper Guide Adjustment
Magnifying Window Over Fence Scale
Hinged Wheel Covers with Safety Lock



SECTION 1: SAFETY

WARNING

For Your Own Safety, Read Instruction Manual Before Operating this Machine

The purpose of safety symbols is to attract your attention to possible hazardous conditions. This manual uses a series of symbols and signal words intended to convey the level of importance of the safety messages. The progression of symbols is described below. Remember that safety messages by themselves do not eliminate danger and are not a substitute for proper accident prevention measures.



Indicates an imminently hazardous situation which, if not avoided, **WILL** result in death or serious injury.



Indicates a potentially hazardous situation which, if not avoided, **COULD** result in death or serious injury.



Indicates a potentially hazardous situation which, if not avoided, **MAY** result in minor or moderate injury. It may also be used to alert against unsafe practices.

NOTICE

This symbol is used to alert the user to useful information about proper operation of the machine.

WARNING

Safety Instructions for Machinery

- 1. READ ENTIRE MANUAL BEFORE STARTING.** Operating machine before reading the manual greatly increases the risk of injury.
- 2. ALWAYS USE ANSI APPROVED SAFETY GLASSES WHEN OPERATING MACHINERY.** Everyday eyeglasses only have impact resistant lenses—they are NOT safety glasses.
- 3. ALWAYS WEAR A NIOSH APPROVED RESPIRATOR WHEN OPERATING MACHINERY THAT PRODUCES DUST.** Most types of dust (wood, metal, etc.) can cause severe respiratory illnesses.
- 4. ALWAYS USE HEARING PROTECTION WHEN OPERATING MACHINERY.** Machinery noise can cause permanent hearing loss.
- 5. WEAR PROPER APPAREL. DO NOT** wear loose clothing, gloves, neckties, rings, or jewelry that can catch in moving parts. Wear protective hair covering to contain long hair and wear non-slip footwear.
- 6. NEVER OPERATE MACHINERY WHEN TIRED OR UNDER THE INFLUENCE OF DRUGS OR ALCOHOL.** Be mentally alert at all times when running machinery.



WARNING

Safety Instructions for Machinery

7. **ONLY ALLOW TRAINED AND PROPERLY SUPERVISED PERSONNEL TO OPERATE MACHINERY.** Make sure operation instructions are safe and clearly understood.
8. **KEEP CHILDREN/VISITORS AWAY.** Keep all children and visitors away from machinery. When machine is not in use, disconnect it from power, lock it out, or disable the switch to make it difficult for unauthorized people to start the machine.
9. **UNATTENDED OPERATION.** Leaving machine unattended while its running greatly increases the risk of an accident or property damage. Turn machine **OFF** and allow all moving parts to come to a complete stop before walking away.
10. **DO NOT USE IN DANGEROUS ENVIRONMENTS.** DO NOT use machinery in damp, wet locations, or where any flammable or noxious fumes may exist.
11. **KEEP WORK AREA CLEAN AND WELL LIGHTED.** Clutter and dark shadows may cause accidents.
12. **USE A GROUNDED POWER SUPPLY RATED FOR THE MACHINE AMPERAGE.** Grounded cords minimize shock hazards. Operating machine on an incorrect size of circuit increases risk of fire.
13. **ALWAYS DISCONNECT FROM POWER SOURCE BEFORE SERVICING MACHINERY.** Make sure switch is in OFF position before reconnecting.
14. **MAINTAIN MACHINERY WITH CARE.** Keep blades sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.
15. **MAKE SURE GUARDS ARE IN PLACE AND WORK CORRECTLY BEFORE USING MACHINERY.**
16. **REMOVE CHUCK KEYS OR ADJUSTING TOOLS.** Make a habit of never leaving chuck keys or other adjustment tools in/on the machine—especially near spindles!
17. **DAMAGED MACHINERY.** Check for binding or misaligned parts, broken parts, loose bolts, other conditions that may impair machine operation. Always repair or replace damaged parts before operation.
18. **DO NOT FORCE MACHINERY.** Work at the speed for which the machine or accessory was designed.
19. **SECURE WORKPIECE.** Use clamps or a vise to hold the workpiece when practical. A secured workpiece protects your hands and frees both hands to operate the machine.
20. **DO NOT OVERREACH.** Maintain stability and balance at all times when operating machine.
21. **MANY MACHINES CAN EJECT WORKPIECES TOWARD OPERATOR.** Know and avoid conditions that cause the workpiece to "kickback."
22. **STABLE MACHINE.** Machines that move during operations greatly increase the risk of injury and loss of control. Verify machines are stable/secure and mobile bases (if used) are locked before starting.
23. **CERTAIN DUST MAY BE HAZARDOUS** to the respiratory systems of people and animals, especially fine dust. Be aware of the type of dust you are exposed to and always wear a respirator designed to filter that type of dust.
24. **EXPERIENCING DIFFICULTIES.** If at any time you are experiencing difficulties performing the intended operation, stop using the machine! Contact our Technical Support Department at (570) 546-9663.



WARNING

Additional Safety Instructions for Bandsaws

1. **BLADE CONDITION.** Do not operate with dull, cracked or badly worn blade. Dull blades require more effort to use and are difficult to control. Inspect blades for cracks and missing teeth before each use.
2. **HAND PLACEMENT.** Placing hands or fingers in the blade path greatly increases the probability of serious injury. Always keep hands or fingers out of the blade path when cutting.
3. **GUARDS.** Do not operate this bandsaw without the blade guard in place.
4. **BLADE REPLACEMENT SAFETY.** Besides disconnecting power when replacing blades, make sure teeth face down toward the table. The force of the cut is always down. Also, make sure the blade is properly tensioned after installing so it will not fly off the wheels.
5. **WORKPIECE HANDLING.** Never hold small workpieces with your fingers during a cut. Always support/feed the workpiece with push stick, table support, vise, or some type of clamping fixture.
6. **CUTTING TECHNIQUES.** Plan your cuts so you always cut out of the wood. DO NOT back the workpiece away from the blade while the saw is running. If you need to back the work out, turn the bandsaw **OFF** and wait for the blade to come to a complete stop, and DO NOT twist or put excessive stress on the blade while backing work away.
7. **BLADE SPEED.** Allow blade to reach full speed before cutting.
8. **UNATTENDED MACHINE.** Machines left unattended while running present multiple hazards, including visitor danger, fire, and self-inflicted damage. Always turn your machine **OFF** before leaving it.
9. **DO NOT FORCE THE MACHINE.** To minimize your risk of personal injury, work at the speed for which the machine or accessory was designed. Always feed stock evenly and smoothly. DO NOT force or twist blade while cutting, especially when sawing small radii.
10. **CUTTING PROPER MATERIAL.** This machine is not designed to cut metal or any material except wood. Attempting to cut other materials may exceed the limits of the machine and increase the risk of personal injury.
11. **MAINTENANCE/SERVICE.** All inspections, adjustments, and maintenance are to be done with the power **OFF** and the plug removed from the outlet. Wait for all moving parts to come to a complete stop.
12. **BLADE CONTROL.** Do not attempt to stop or slow the blade with your hand or a workpiece. Allow the blade to stop on its own, unless your machine is equipped with a brake.
13. **EXPERIENCING DIFFICULTIES.** If at any time you are experiencing difficulties performing the intended operation, stop using the machine! Contact our Technical Support Department at (570) 546-9663.

WARNING

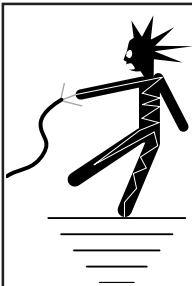
Like all machinery there is potential danger when operating this bandsaw. Accidents are frequently caused by lack of familiarity or failure to pay attention. Use this bandsaw with respect and caution to reduce the risk of operator injury. If normal safety precautions are overlooked or ignored, serious personal injury may occur.



SECTION 2: CIRCUIT REQUIREMENTS

WARNING

Serious personal injury could occur if you connect the machine to the power source before you have completed the setup process. **DO NOT** connect the machine to the power source until instructed after setup.



WARNING

Electrocution or fire could result if this machine is not installed to code. You **MUST** ensure compliance by checking with a qualified electrician!

NOTICE

The Model G0569 is prewired for 220V operation. If you plan to use your machine at 440V, you **MUST** have a qualified electrician perform the 440V conversion described on Page 12.

Full Load Amp Draw

G0568 220V 1-Phase.....	30 Amp
G0569 220V 3-Phase.....	20 Amp
G0569 440V 3-Phase.....	10 Amp

Power Supply Circuit Requirements

The power supply circuit for your machine **MUST** be grounded and rated for the amperage given below. Never replace a circuit breaker on an existing circuit with one of higher amperage without consulting a qualified electrician to ensure compliance with wiring codes. **If you are unsure about the wiring codes in your area or you plan to connect your machine to a shared circuit, consult a qualified electrician.**

G0568@ 220V.....	40 Amps
G0569@ 220V.....	30 Amps
G0569@ 440V.....	15 Amps

Minimum Cord Requirements

For 220V 3-Phase connection on the Model G0569, use a stranded-copper flexible cord that meets the minimum requirements listed below, does not exceed 50 ft., and has an insulation type that starts with "S." A qualified electrician **MUST** determine the best cord to use in your environment depending on exposure to moisture, heat, and oils.

For 220V, 1-Phase connection (Model G0568) or 440V 3-Phase connection (Model G0569), an electrician **MUST** hardwire the machine. The electrician who hardwires the machine will determine the appropriate wire to use inside the conduit.

G0568 220V 1-Phase..... Electrician to Hardwire
G0569 220V 3-Phase.. 4 Wire/10 AWG, 300VAC
G0569 440V 3-Phase..... Electrician to Hardwire

Power Connection Device

The power connection device depends on the type of installed or planned service. We recommend using one of the devices shown in **Figure 4**, depending on the voltage being used.

G0568 @ 220V 1-Phase Hardwired Switch
G0569 @ 220V 3-Phase L15-30
G0569 440V 3-Phase..... Hardwired Switch

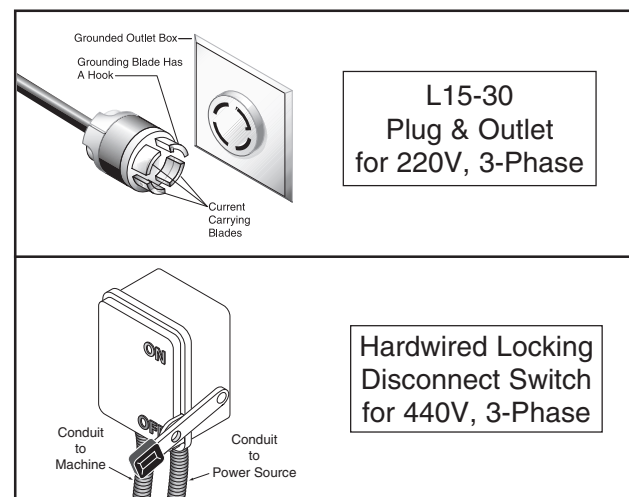


Figure 4. Recommended connection types.



Phase Converter Precaution

The power from the manufactured leg may damage electrical components if connected to the wrong incoming power terminal on your machine. Only connect the manufactured leg to the L2 terminal. **DO NOT use a static phase converter, as they notoriously damage electrical components.**

440V Conversion

The Model G0569 can be converted for 440V operation. This conversion job consists of disconnecting the saw from the power source, changing the connections on the magnetic switch and rewiring the motor for 440V operation.

The Model G0569 440V Conversion Kit (Part P0569082A) for this procedure can be purchased by calling Grizzly Customer Service at (800) 523-4777.

All wiring changes must be inspected by a qualified electrician before the saw is connected to the power source. If, at any time during this procedure you need help, call Grizzly Tech Support at (570) 546-9663.

To rewire the Model G0569 for 440V operation:

1. DISCONNECT BANDSAW FROM POWER!
2. Remove the magnetic switch cover, then disconnect the 220V magnetic switch (**Figure 5**).

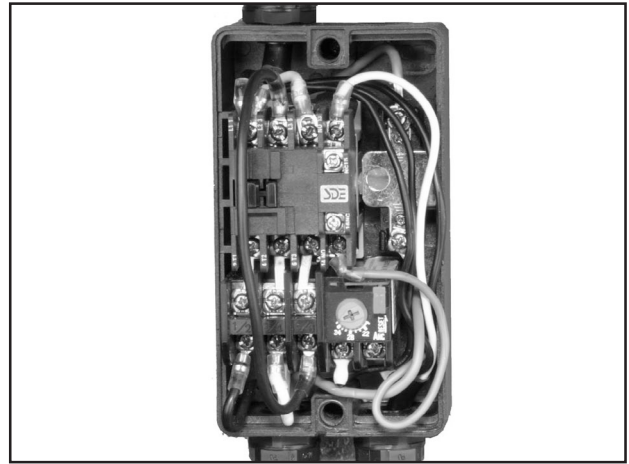


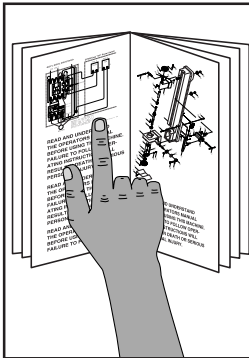
Figure 5. 220V magnetic switch

3. Install the 440V magnetic switch and wire it according to the **G0569 Wiring Diagram** on **Page 63**.
4. Remove the motor junction box cover, rewire the motor as shown on the diagram located inside the junction box, then reinstall the cover.

Note: The reference wiring diagram on **Page 63** was current at the time of printing, but always use the wiring diagram provided inside the motor junction box, as it will reflect any changes to the motor shipped with your machine.

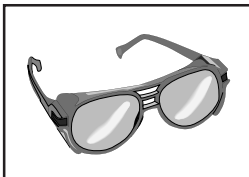


SECTION 3: SETUP



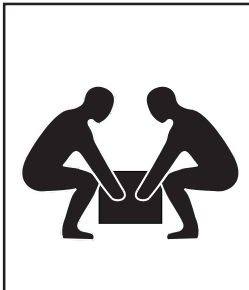
⚠️WARNING

This machine presents serious injury hazards to untrained users. Read through this entire manual to become familiar with the controls and operations before starting the machine!



⚠️WARNING

Wear safety glasses during the entire setup process!



⚠️WARNING

This machine and its components are very heavy. Get lifting help or use power lifting equipment such as a forklift to move heavy items.

Needed for Setup

The following are needed to complete the setup process, but are not included with your machine.

Description	Qty
• Safety Glasses	1
• Cleaner/Degreaser (Page 16)	As Needed
• Disposable Shop Rags.....	As Needed
• Forklift.....	1
• Chains w/Safety Hooks 1000 lb Capacity ..	2
• Straightedge 2'	1
• Fine Ruler.....	1
• Machinist's Square	1
• Feeler Gauges 0.016", 0.004"	1 Ea
• Screwdriver Phillips #2	1
• Screwdriver Flat Head #2.....	1
• Dust Collection System	1
• Dust Hose 4"	1
• Hose Clamps 4"	2

Unpacking

Your machine was carefully packaged for safe transportation. Remove the packaging materials from around your machine and inspect it. If you discover the machine is damaged, *please immediately call Customer Service at (570) 546-9663 for advice.*

Save the containers and all packing materials for possible inspection by the carrier or its agent. *Otherwise, filing a freight claim can be difficult.*

When you are completely satisfied with the condition of your shipment, inventory the contents.



Inventory

The following is a description of the main components shipped with your machine. Lay the components out to inventory them.

Note: If you can't find an item on this list, check the mounting location on the machine or examine the packaging materials carefully. Occasionally we pre-install certain components for shipping purposes.

Box 1: (Figure 6-7)	Qty
A. Bandsaw (not shown)	1
B. Hand Knob	1
C. Fence.....	1
D. Handwheel	1
E. Eye Bolts	2
F. Hex Wrench 5mm.....	1
G. Hex Wrench 6mm.....	1
H. Open End Wrench 10 x 13	1
I. Open End Wrench 17 x 19	1
J. Miter Gauge.....	1
K. Handwheel Handle	1

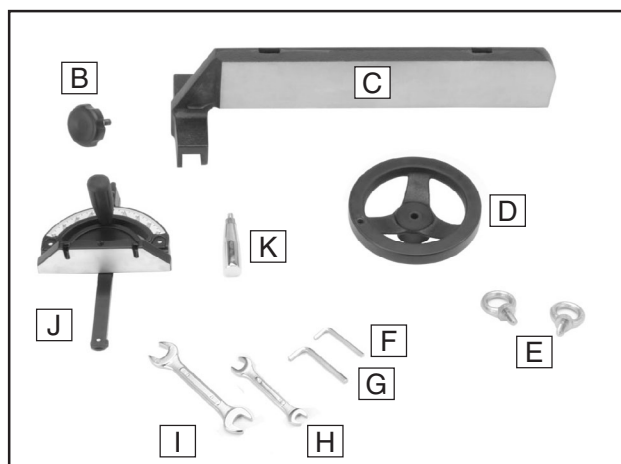


Figure 6. Main inventory.

L. Riser Blocks	2
M. Hardware Bag	1
—Hex Bolts M12-1.75 x 110.....	4
—Flat Washers 12mm.....	4
—Lock Washers 12mm	4

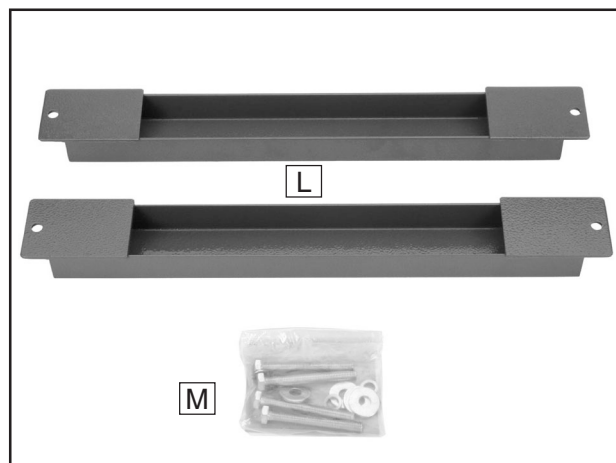
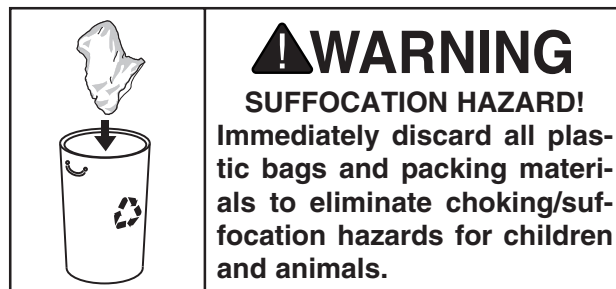


Figure 7. Riser blocks and hardware.

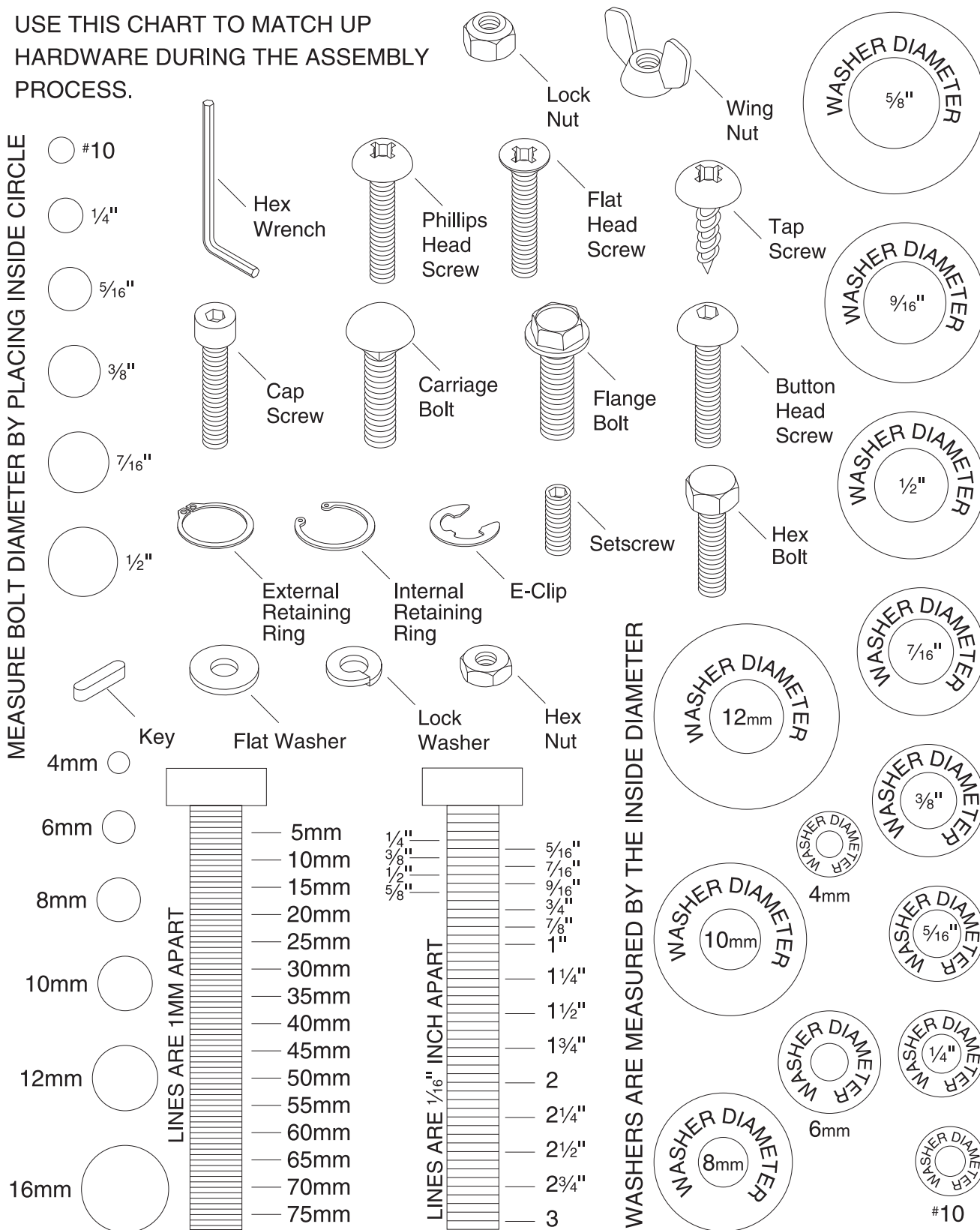
If any nonproprietary parts are missing (e.g. a nut or a washer), we will gladly replace them; or for the sake of expediency, replacements can be obtained at your local hardware store.



Hardware Recognition Chart

USE THIS CHART TO MATCH UP
HARDWARE DURING THE ASSEMBLY
PROCESS.

MEASURE BOLT DIAMETER BY PLACING INSIDE CIRCLE



Cleanup

The unpainted surfaces of your machine are coated with a heavy-duty rust preventative that prevents corrosion during shipment and storage.

This rust preventative has been your machine's close ally and guardian since it left the factory. If your machine arrived to you free of rust, then be thankful that the rust preventative protected it during its journey...and try to stay thankful as you clean it off, because it can be challenging to remove if you are unprepared and impatient.

Plan on spending some time cleaning your machine. The time you spend doing this will reward you with smooth sliding parts and a better appreciation for the proper care of your machine's unpainted surfaces.

Although there are many ways to successfully remove the rust preventative, these instructions walk you through what works well for us.

Before cleaning, gather the following:

- Disposable Rags
- Cleaner/degreaser (**Figure 8**)
- Safety glasses & disposable gloves

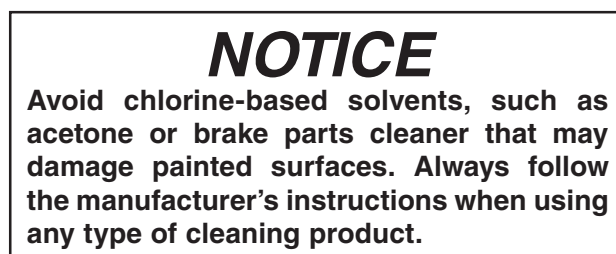
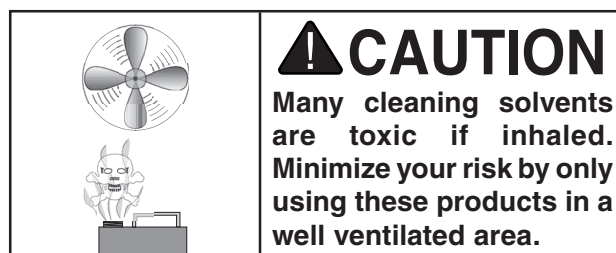
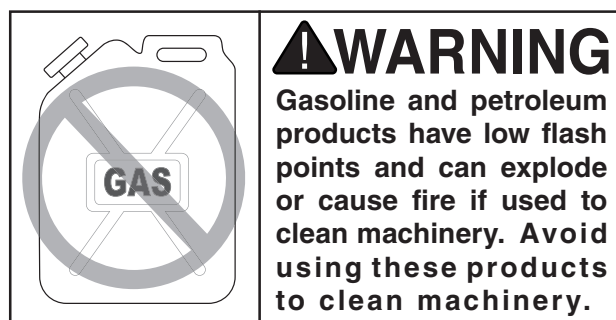
H9692—Orange Power Cleaner & Degreaser

One of the best cleaners we've found for quickly and easily removing rust preventative.



Figure 8. Model H9692 Industrial Orange Power Cleaner/Degreaser (99.9% biodegradable).

Note: In a pinch, automotive degreasers, mineral spirits or WD-40 can be used to remove rust preventative. Before using these products, though, test them on an unnoticeable area of your paint to make sure they will not damage it.



Basic steps for removing Rust preventative:

1. Put on safety glasses and disposable gloves.
2. Coat all surfaces that have rust preventative with a liberal amount of your cleaner/degreaser and let them soak for few minutes.
3. Wipe off the surfaces. If your cleaner/degreaser is effective, the rust preventative will wipe off easily.

Note: To clean off thick coats of rust preventative on flat surfaces, such as tables, use a PLASTIC paint scraper to scrape off the majority of the coating before wiping it off with your rag. (Do not use a metal scraper or you may scratch your machine.)

4. Repeat **Steps 2–3** as necessary until clean, then coat all unpainted surfaces with a quality metal protectant to prevent rust.



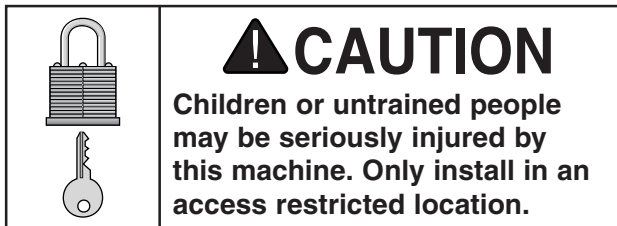
Site Considerations

Weight Load

Refer to the **Machine Data Sheet** for the weight of your machine. Make sure that the surface upon which the machine is placed will bear the weight of the machine, additional equipment that may be installed on the machine, and the heaviest workpiece that will be used. Additionally, consider the weight of the operator and any dynamic loading that may occur when operating the machine.

Space Allocation

Consider the largest size of workpiece that will be processed through this machine and provide enough space around the machine for adequate operator material handling or the installation of auxiliary equipment. With permanent installations, leave enough space around the machine to open or remove doors/covers as required by the maintenance and service described in this manual. See **Figure 9** for minimum working clearances.



Physical Environment

Operate this machine in a dry environment that is free from moisture, hazardous chemicals, or airborne abrasives or contaminants. Avoid using this machine where the ambient temperature range exceeds 41°–104°F or the relative humidity range exceeds 20–95% (noncondensing). Also, do not use this machine in an environment that is subject to vibration, shocks, or bumps.

Electrical Installation

Place this machine near an existing power source. Make sure all power cords are protected from traffic, material handling, moisture, chemicals, or other hazards. Make sure to leave access to a means of disconnecting the power source or engaging a lockout/tagout device.

Lighting

Lighting around the machine must be adequate enough that operations can be performed safely. Shadows, glare, or strobe effects that may distract or impede the operator must be eliminated.

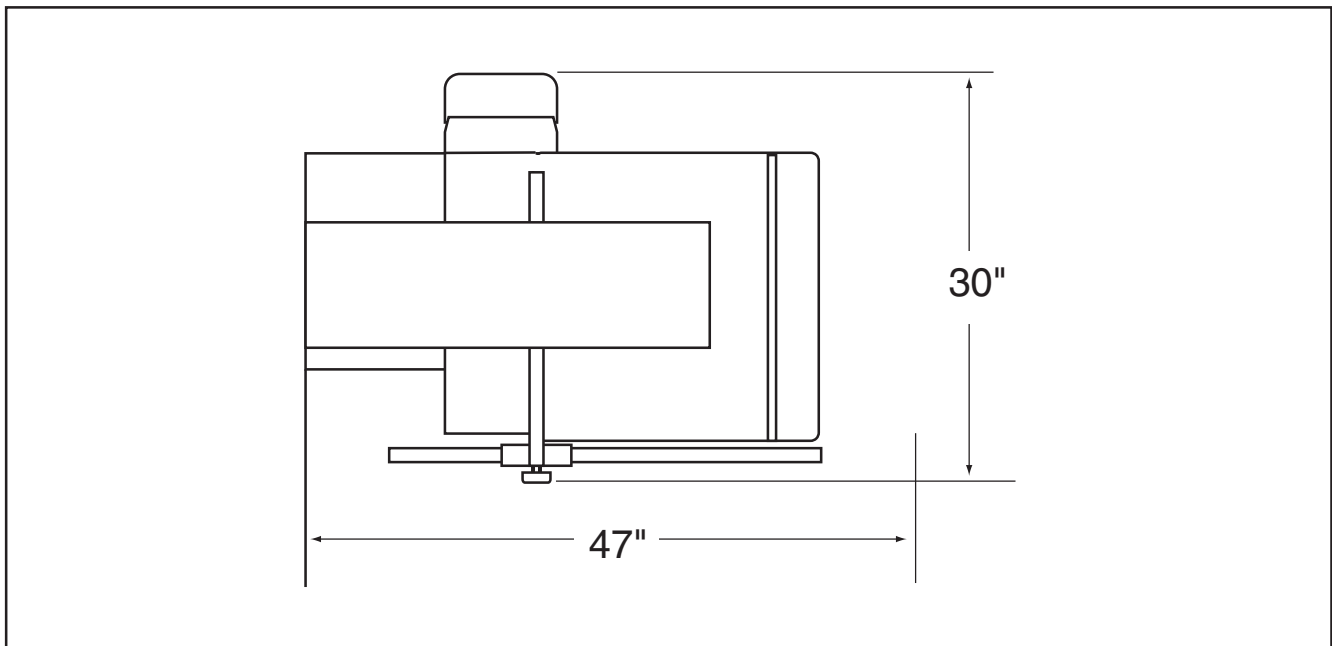


Figure 9. Minimum working clearances.



Moving & Placing Base Unit

WARNING

This is an extremely heavy machine. Serious personal injury may occur if safe moving methods are not followed. To be safe, you will need assistance and a forklift or a hoist when removing the machine from the crate. Use a chain or a lifting strap with a minimum of 1,000 lbs. lifting capacity. If the chain or lifting strap breaks, serious personal injury may occur.

Take special care when moving this bandsaw. Only use the following methods to lift or move this bandsaw.

To move and place the bandsaw using the eye bolts:

1. Unbolt the bandsaw from the pallet.
2. Install the eye bolts shown in **Figure 10**, making sure they are threaded all the way in, then place the lifting hooks through the eye bolts and lift slowly with a forklift.
3. Remove the pallet and slowly set the bandsaw into position.

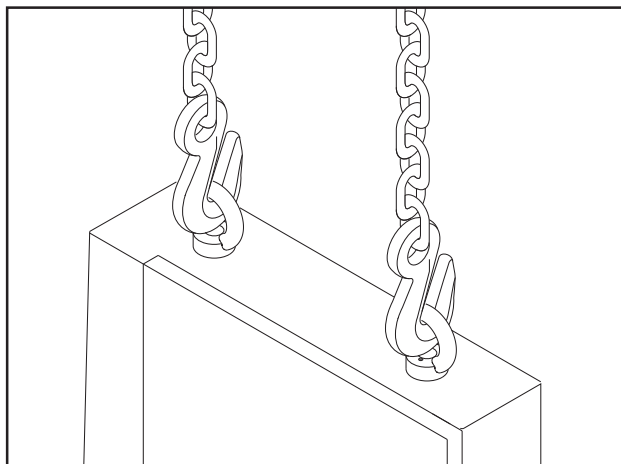


Figure 10. Lifting the bandsaw.

To move and place the bandsaw using wood shims:

1. Carefully place the forklift forks under the head and install a 1x4 shim between the head and the left fork and a 2x4 shim between the head and right fork so the bandsaw is level, as shown in **Figure 11**.
2. Unbolt the bandsaw from the pallet.

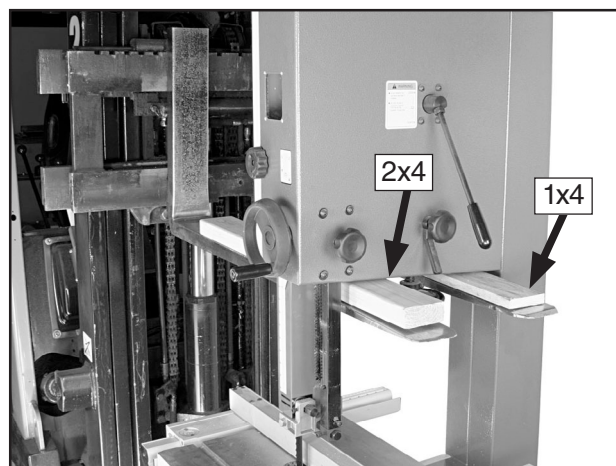


Figure 11. Example of lifting bandsaw with forklift using wood shims.

3. Lift the bandsaw off of the pallet, remove the pallet, and slowly set the bandsaw into position.

Note: If you are concerned about your forklift forks hitting the tension handwheel, remove the handwheel before positioning the forks, then reinstall it after lifting.



Mounting to Shop Floor

Although not required, we recommend that you mount your new machine to the floor. Because this is an optional step and floor materials may vary, floor mounting hardware is not included. However, you must level your machine with a precision level.

Bolting to Concrete Floors

Lag shield anchors with lag bolts (Figure 12) and anchor studs are two popular methods for anchoring an object to a concrete floor. We suggest you research the many options and methods for mounting your machine and choose the best that fits your specific application.

NOTICE

Anchor studs are stronger and more permanent alternatives to lag shield anchors; however, they will stick out of the floor, which may cause a tripping hazard if you decide to move your machine.

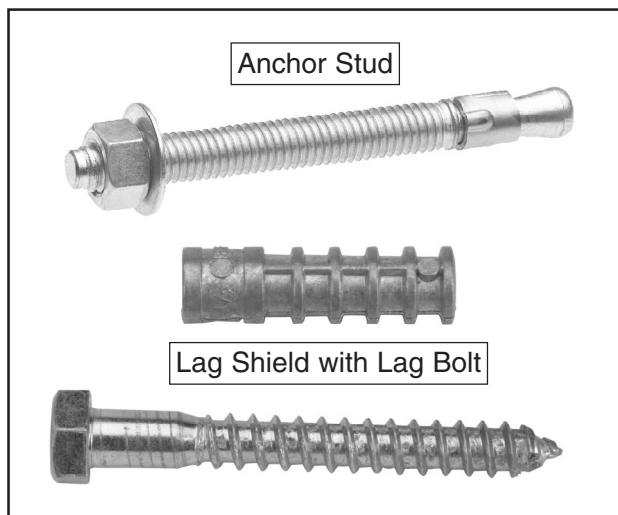


Figure 12. Typical fasteners for mounting to concrete floors.

Riser Blocks

Riser blocks, shown in Figure 13, are included with the Model G0568/G0569 to match the height of the table to your personal preference or needs. This added feature, when installed, lifts the working table height from 32½" to 34½".



Figure 13. Optional riser blocks and hardware.

To install the riser blocks:

1. Lift the Model G0568/G0569 with a forklift or other power equipment.
2. Place the four hex bolts, lock washers, and flat washers, down through the holes in the base.
3. Locate and align the threaded holes in the riser bars, then securely tighten the bolts.

Note: The riser bars have tabs with holes for mounting the bandsaw unit to the floor to maximize stability. We highly recommend utilizing them and securing the bandsaw to the floor.



Fence

To install the fence:

1. Remove the cap screws holding the rail onto the table, and remove the rail.
2. Flip the rail over and reinstall with the caps screws removed in **Step 1**, as shown in **Figure 14**.

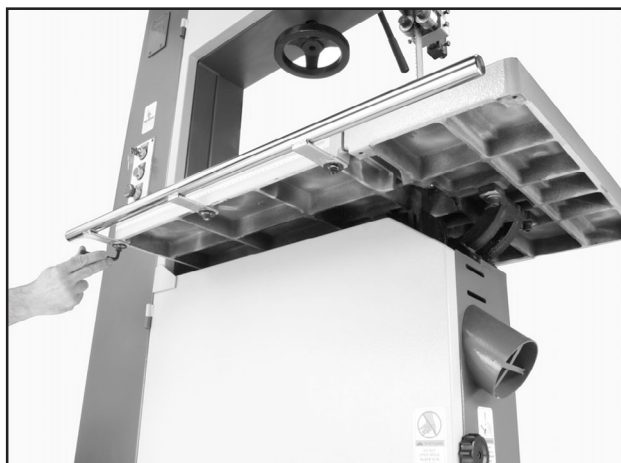


Figure 14. Tightening guard rail cap screws.

3. Place the fence on the rail (see **Figure 15**) and tighten securely with the hand knob. See **Page 29** to calibrate the pointer.



Figure 15. Installing fence onto rail.

Handwheel

To install the handwheel:

1. Slide the handwheel (**Figure 16**) on to the shaft.
2. Tighten the cap screw in the handwheel securely.
3. Thread the handle in to the handwheel and tighten with the 14mm wrench.

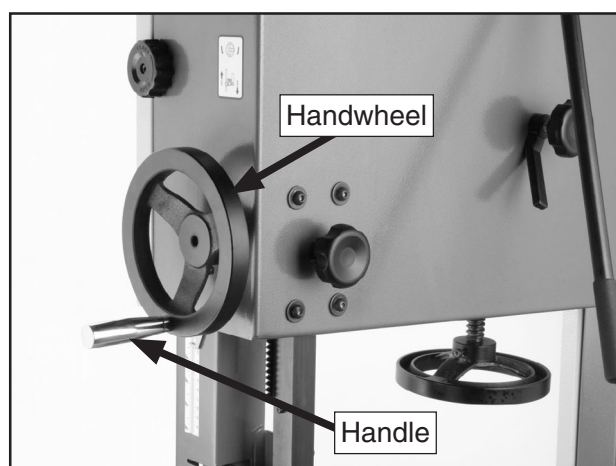


Figure 16. Handwheel correctly installed.



Dust Collection

⚠ CAUTION

DO NOT operate the Model G0568/G0569 without an adequate dust collection system. This bandsaw creates substantial amounts of wood dust while operating. Failure to use a dust collection system can result in short and long-term respiratory illness.

Recommended CFM at each Dust Port: 400

Do not confuse this CFM recommendation with the rating of the dust collector. To determine the CFM at the dust port, you must consider these variables: (1) CFM rating of the dust collector, (2) hose type and length between the dust collector and the machine, (3) number of branches or wyes, and (4) amount of other open lines throughout the system. Explaining how to calculate these variables is beyond the scope of this manual. Consult an expert or purchase a good dust collection "how-to" book.

To connect a dust collection hose:

1. Fit a 4" dust hose over each dust port, as shown in **Figure 17**, and secure in place with a hose clamp.
2. Tug each hose to make sure it does not come off. **Note:** A tight fit is necessary for proper performance.

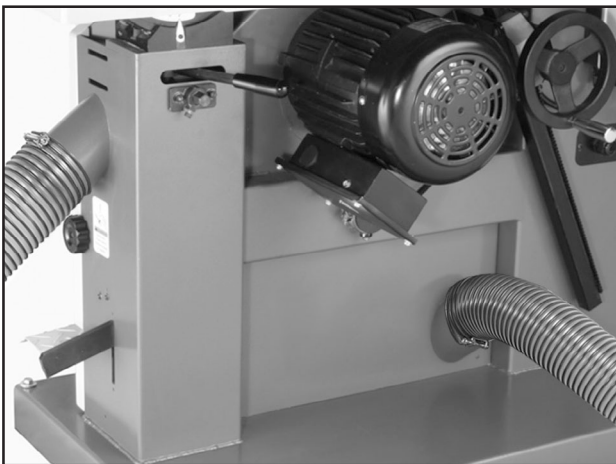
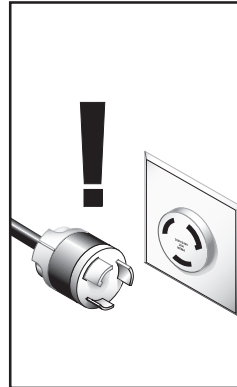


Figure 17. Dust hoses attached to dust port.

Blade Tracking

⚠ WARNING

Personal injury or death can occur if the machine starts while your hand is touching the bandsaw wheel during tracking adjustments. Disconnect power from the bandsaw before performing blade tracking adjustments.



The blade tracking is primarily affected by the tilt of the upper wheel, also known as "Center Tracking"; and the alignment of both wheels, also known as "Coplanar Tracking." (For Coplanar Tracking, see the **Wheel Alignment** instructions on **Page 59**.)

The wheels on this bandsaw were aligned at the factory, so Center Tracking is the only adjustment that needs to be performed when the saw is new.

To center track the blade:

1. DISCONNECT BANDSAW FROM POWER!
2. Make sure the upper and lower blade guides are adjusted away from the blade (see **Page 30**).
3. Move the quick tension lever to the tightened position and turn the blade tension handwheel until the blade tension matches the mark on the blade tension scale for the appropriate blade thickness (**Figure 18**).



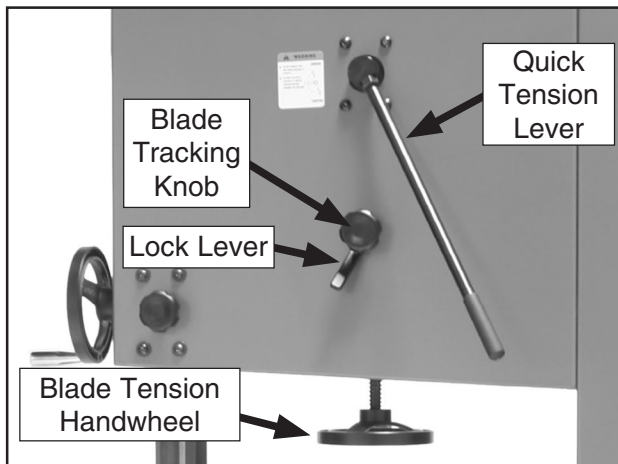


Figure 18. Blade tensioning controls.

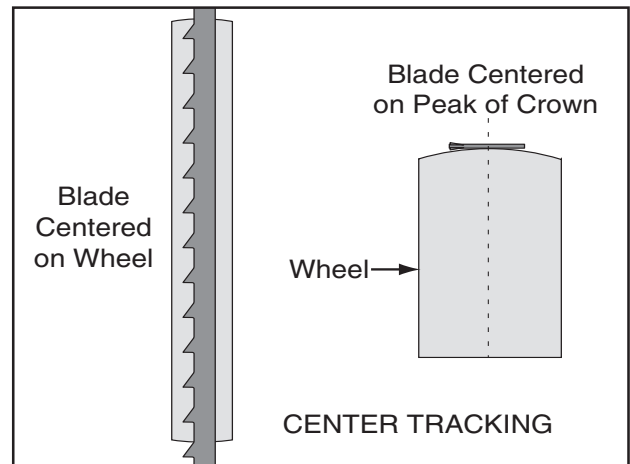


Figure 19. Center tracking profiles.

4. Open the upper wheel cover.
5. Spin the upper wheel by hand at least three times and watch how the blade rides on the crown of the wheel. Refer to **Figure 19** for an illustration of this concept.

—If the blade rides in the center of the upper wheel and is centered on the peak of the wheel crown, then the bandsaw is already center tracked properly and no further adjustments are needed at this time.

—If the blade does not ride in the center of the upper wheel and is not centered on the peak of the wheel crown, then continue with the following steps.

⚠ CAUTION

The cast iron spokes may have sharp edges and the blade teeth may extend beyond the edge of the wheel, creating a laceration hazard. Be careful when turning the wheels by hand.

6. Loosen the lock lever (**Figure 20**) so that the blade tracking knob can rotate.

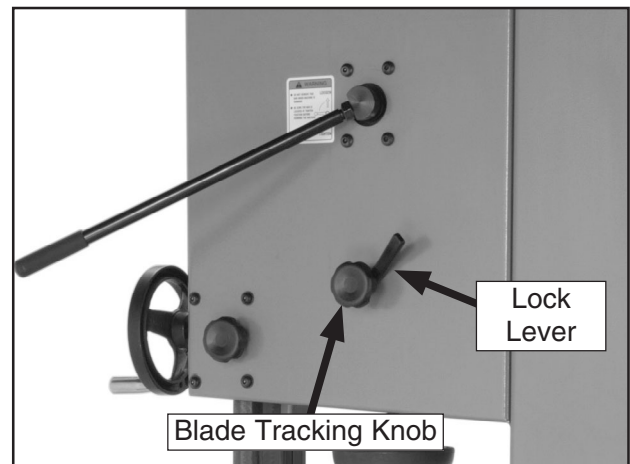


Figure 20. Blade tracking controls.

7. Spin the upper wheel with one hand and rotate the blade tracking knob with the other hand to make the blade ride in the center of the bandsaw wheel tire.
8. Tighten the lock lever and close the upper wheel cover.

Tip: For the best performance from your saw, regularly maintain proper tracking of the blade.

NOTICE

Changes in the blade tension may change the blade tracking.



Power Connection

Before connecting to power, read through the **SECTION 2: CIRCUIT REQUIREMENTS** section on **Page 11** to check that your setup follows the safety and circuit requirements for this machine. Be sure to also have your electrician on hand for the "Test Run" in case the power is connected out of phase (Model G0569 only).

WARNING



Attempting to connect this machine to the power source without a qualified electrician greatly increases the risk of electrocution, fire, or machine damage.

To connect the bandsaw to the power source:

1. Remove the screws securing the power supply terminal box.
2. Feed the power wires through the strain relief on the bottom of the terminal box, tighten the strain relief, connect the cord to the terminals shown in **Figure 21** or **22** then reinstall the terminal box cover.

Note (Model G0569 Only): When using a phase converter, connect the manufactured power leg or "wild wire" to the L2 terminal (**Figure 22**). The L2 terminal can handle power fluctuation because it is wired directly to the motor. The other wires connect to the controls and must be consistent to prevent damage.

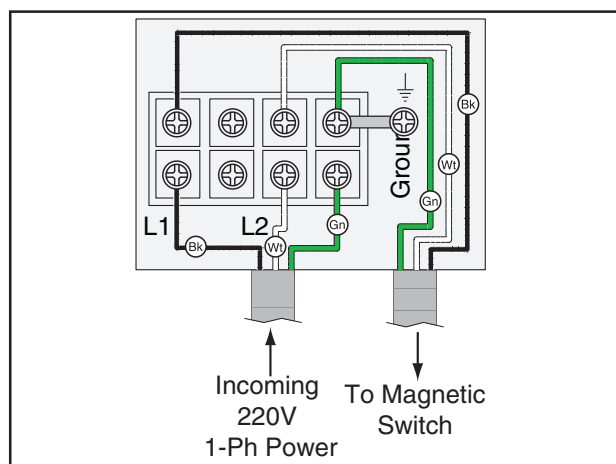


Figure 21. G0568 terminal box connection.

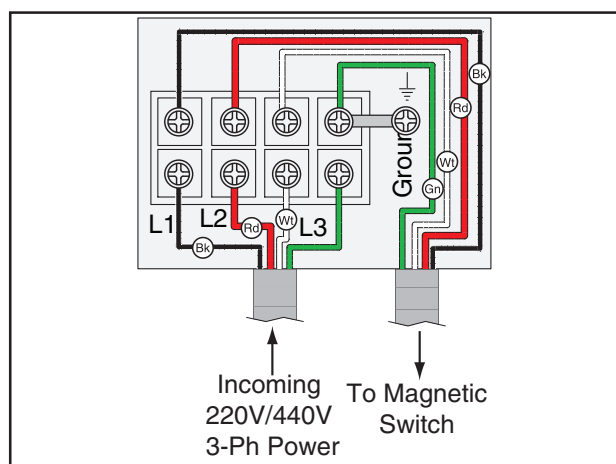


Figure 22. G0569 terminal box connection.

3. **Model G0568 1-Phase, 220V and G0569 3-Phase, 440V Operation Only:** Shut off the main power at the power source circuit breaker and attach the wires to the locking shutoff switch.

Model G0569 3-Phase, 220V Operation:

Connect the power cord with an L15-30 plug to an L15-30 receptacle.



Test Run

Once the assembly is complete, test run your machine to make sure it runs properly and is ready for regular operation.

The test run consists of verifying the following: 1) The motor powers up and runs correctly, 2) the safety disabling mechanism on the switch works correctly, and 3) the stop button safety feature works correctly.

If, during the test run, you cannot easily locate the source of an unusual noise or vibration, stop using the machine immediately, then review **Troubleshooting** on **Page 50**.

If you still cannot remedy a problem, contact our Tech Support at (570) 546-9663 for assistance.

To test run the machine:

1. Make sure you have read the safety instructions at the beginning of the manual and that the machine is set up properly.
2. Make sure all tools and objects used during setup are cleared away from the machine.
3. Connect the machine to the power source.
4. Verify that the machine is operating correctly by turning the switch disabling key (**Figure 23**) to "1" and turning the machine **ON**.

—When operating correctly, the machine runs smoothly with little or no vibration or rubbing noises.

—Investigate and correct strange or unusual noises or vibrations before operating the machine further. Always disconnect the machine from power when investigating or correcting potential problems.



Figure 23. G0568 switch disabling key and ON/OFF switch.

5. Press the OFF button to stop the machine.
6. WITHOUT resetting the OFF button, press the ON button. The machine should not start.
 - If the machine does not start, the OFF button safety feature is working correctly.
 - If the machine does start (with the stop button pushed in), immediately disconnect power to the machine. The OFF button safety feature is not working correctly. This safety feature must work properly before proceeding with regular operations. Call Tech Support for help.
7. Push the OFF button in, then twist it clockwise so it pops out. When the OFF button pops out, the switch is reset and ready for operation (see **Figure 24**).

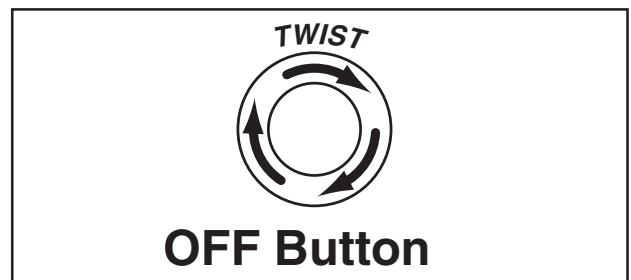


Figure 24. Resetting the switch.



8. Turn the bandsaw **ON** and allow it to reach full speed, then press the foot brake (**Figure 45, Page 35**) completely.

—If the bandsaw blade stops the foot brake is working correctly; continue to the next step.

—If the bandsaw blade does not stop moving, the foot brake feature is not working correctly. This safety feature must work properly before proceeding with regular operations. Call Tech Support for help.

9. Make sure the blade has fully stopped, open the top and bottom wheel covers a few inches, then turn the bandsaw **ON**.

—If the bandsaw does not start the upper wheel cover limit switch (**Figure 25**) is working correctly; continue to the next step.

—If the bandsaw starts, immediately turn the machine **OFF** and disconnect power. The upper wheel cover limit switch is not working correctly. This safety feature must work properly before proceeding with regular operations. Call Tech Support for help.

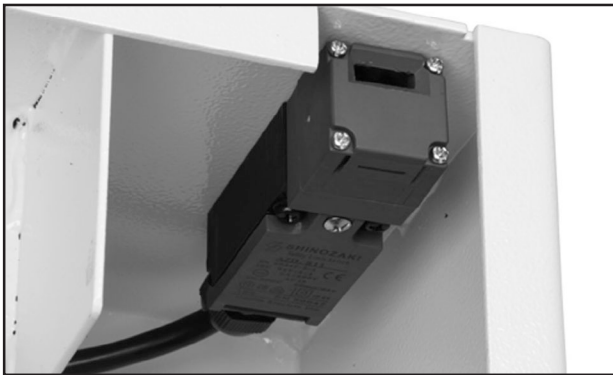


Figure 25. Upper door limit switch.

10. Close the upper and lower wheel covers.

11. Turn the switch disabling key to "0", as shown in **Figure 23** on **Page 24**.

12. Try to turn the machine **ON**.

—If the bandsaw does not start, the switch disabling feature is working as designed. The Test Run is complete.

—If the bandsaw starts, immediately disconnect power. The switch disabling feature is not working correctly. This safety feature must work properly before proceeding with regular operations. Call Tech Support for help.

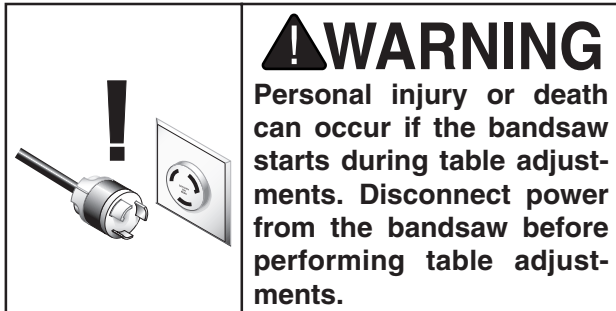
13. **Model G0569 Only:** Verify that the power is not connected out of phase by starting/stopping the machine and determining if the motor turns in the correct direction, using the criteria below:

—If the blade moves down and toward the table (as standing in front of the machine), it is turning in the correct direction.

—If the blade turns up and away from the table, it is turning in the wrong direction. Stop the machine, disconnect the power source, then swap any two of the three power wires that connect to the machine.



Table Stop Calibration



The positive stop allows the table to be quickly and accurately returned to the horizontal (0°) position after being adjusted to a different angle.

To set the positive stop:

1. DISCONNECT BANDSAW FROM POWER!
2. Adjust the blade tension to the appropriate level for the blade size on the blade tension scale (see **Page 30**).
3. Loosen the jam nut that locks the positive stop bolt in place.

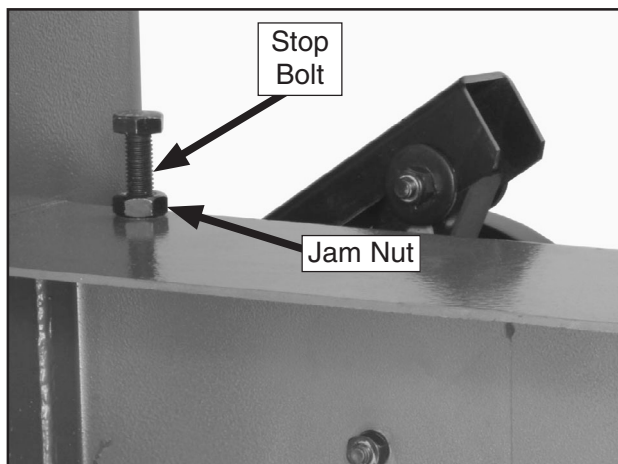


Figure 26. Positive stop bolt and jam nut (as viewed from front).

4. Raise the guide post and place a machinist's square on the table next to the side of the blade as illustrated in **Figure 27**. Adjust the table square with the blade using the table tilt handwheel, then secure with the table tilt lock lever.

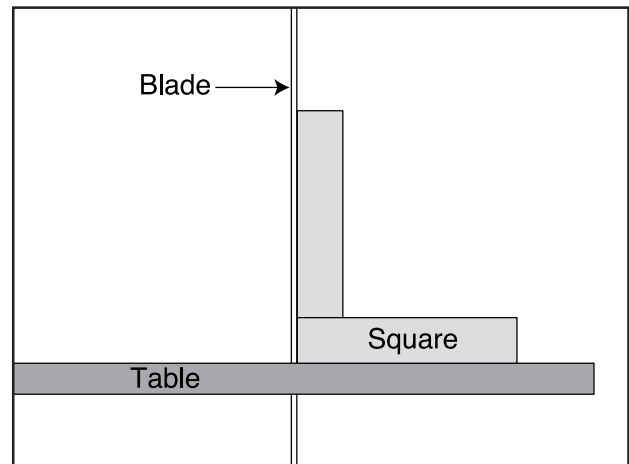


Figure 27. Squaring table to blade.

5. Adjust the positive stop bolt so it just touches the table and secure it by tightening the jam nut against the bandsaw.
6. Check the adjustment for accuracy once you have tightened the jam nut.

Table Tilt Calibration

To calibrate the table tilt pointer:

1. DISCONNECT BANDSAW FROM POWER!
2. Follow **Steps 2-6 in Table Stop Calibration**.
3. Loosen the screw on the table tilt scale pointer (see **Figure 28**), but do not remove it.

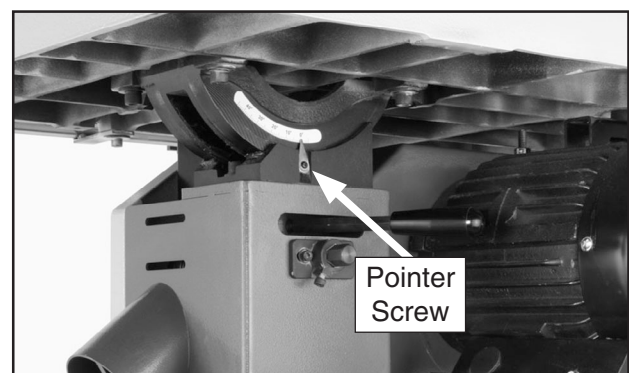


Figure 28. Table tilt pointer.

4. Align the tip of the pointer with the 0° mark on the table tilt scale, then tighten the screw to secure the setting.



Aligning Table

To ensure cutting accuracy, the table should be aligned so that the miter slot is parallel to the bandsaw blade. This procedure works best with a 1½" blade installed.

To align the table so the miter slot is parallel to the bandsaw blade:

1. Make sure that the blade is tracking properly and that it is correctly tensioned.
2. **DISCONNECT BANDSAW FROM POWER!**
3. Loosen the four trunnion cap screws that secure the table to the trunnions (**Figure 29**).

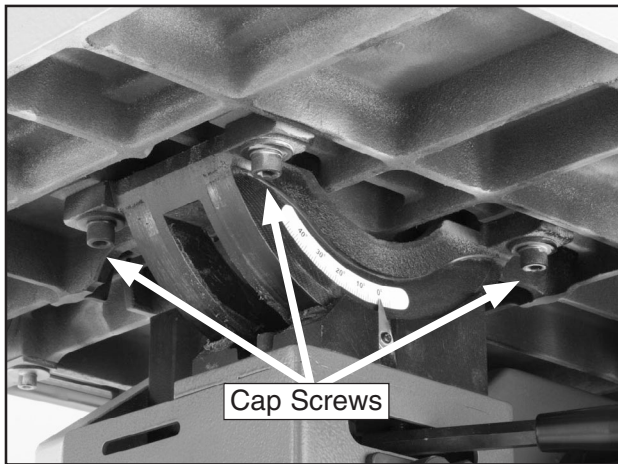


Figure 29. Cap screws securing table to trunnion.

4. Place an accurate straightedge along the blade. The straightedge should lightly touch both the front and back of the blade. **Note:** *Make sure the straightedge does not go across a tooth.*

5. Use a fine ruler to accurately gauge the distance between the straightedge and the miter slot. The distance you measure should be the same at both the front and the back of the table (see **Figure 30**).

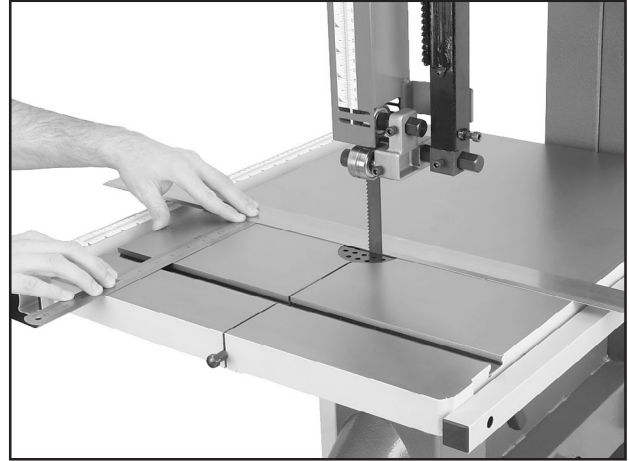


Figure 30. Example of measuring for miter slot to be parallel with blade.

6. Adjust the table as needed for proper alignment.
7. Tighten the trunnion cap screws when the alignment is correct.



Aligning Fence

To ensure cutting accuracy when the fence is first installed, the fence should be aligned with the miter slot.

To align the fence parallel with the miter slot:

1. DISCONNECT BANDSAW FROM POWER!
2. Make sure the miter slot is aligned with the bandsaw blade (see **Page 27**).
3. If the fence is mounted on the left-hand side of the blade, remove it and remount it next to the miter slot.
4. Loosen the three cap screws that secure the rail to the table (**Figure 31**).

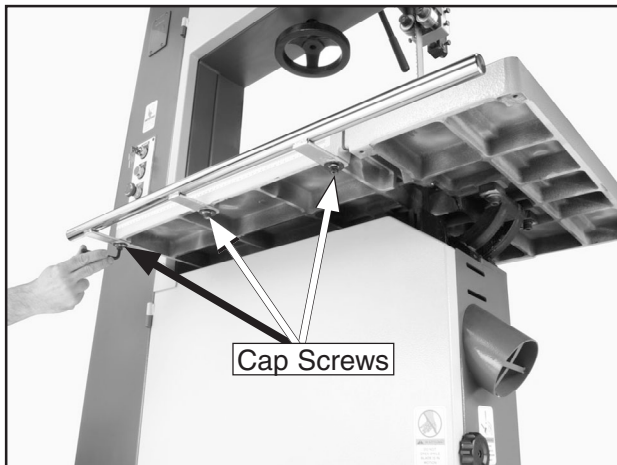


Figure 31. Cap screws securing rail to table.

5. Adjust the fence face parallel with the edge of the miter slot, as shown in **Figure 32**.

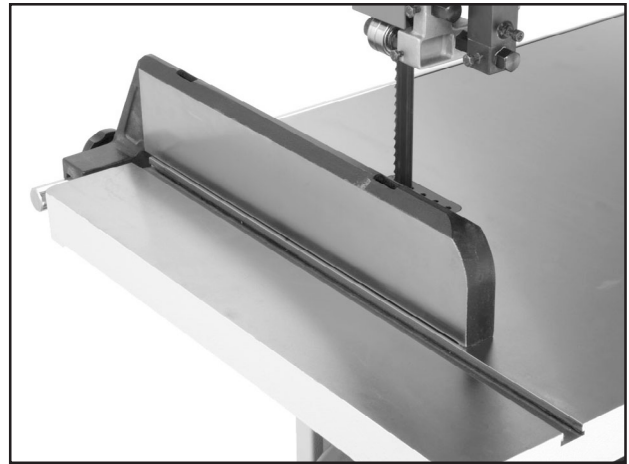


Figure 32. Example of fence square with miter slot.

6. Tighten the three cap screws that secure the rail to the table, being careful not to move the fence.

NOTICE

Adjusting the fence parallel to the miter slot does not guarantee straight cuts. The miter slot may need to be adjusted parallel to the side of the blade. Refer to the "Aligning Table" instructions on Page 27.



Pointer Calibration

Your new bandsaw is equipped with a fence measurement system that includes a fence pointer, which must be calibrated when the bandsaw is first set up.

To calibrate the pointer:

1. If the fence is mounted on the right-hand side of the blade, remove it and re-install it on the left-hand side of the blade.
2. Place the fence flush against the bandsaw blade (**Figure 33**).

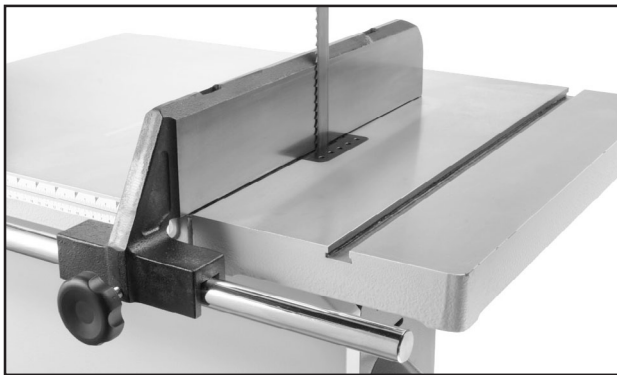


Figure 33. Example of fence flush with blade.

3. Loosen the pointer adjustment screw (**Figure 34**) and set the pointer in line with "0" and the measurement scale on the table.



Figure 34. Fence pointer adjustment screw.

4. Tighten the pointer adjustment screw.

Miter Gauge

The miter gauge needs to be calibrated to the blade when it is first mounted in the miter slot.

To calibrate the miter gauge:

1. Place one edge of a machinist's square against the face of the miter gauge and the other against the blade face, as shown in **Figure 35**.

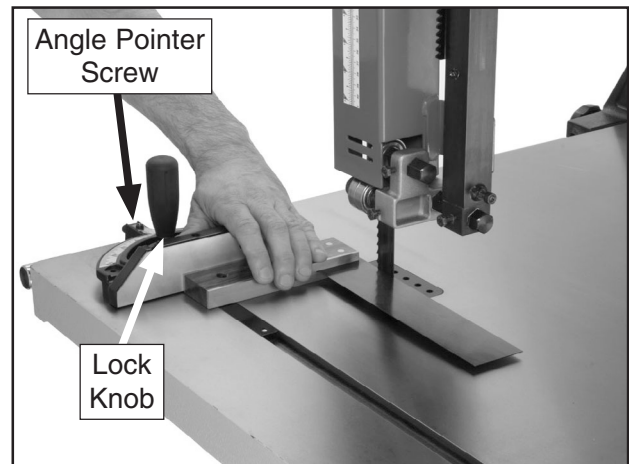


Figure 35. Example of squaring miter gauge to blade.

2. Loosen the lock knob on the miter gauge and adjust the gauge flush with the edge of the square.
3. Tighten the lock knob, and verify the setting.

Note: Sometimes the tightening procedure can affect the adjustment.

4. Loosen the screw that secures the angle pointer and adjust the pointer to the 0° mark on the scale.
5. Retighten the screw that secures the angle pointer.



Tensioning Blade

A properly tensioned blade is essential for making accurate cuts and is required before making many bandsaw adjustments. (Everytime you replace the blade, perform this procedure because all blades tension differently.)

To tension the bandsaw blade:

1. Complete the **Test Run** procedure and make sure the blade is tracking properly (see **Page 21**).
2. Raise the upper blade guide assembly as high as it will go, and adjust the upper and lower guide blocks as far away from the blade as possible (see **Adjusting Blade Guide Bearings**).

***Note:** This procedure will NOT work if the guide blocks have any contact with the blade.*
3. Move the quick tension lever to the tightened position and turn the blade tension handwheel until the blade tension matches the mark on the blade tension scale for the appropriate blade thickness (See **Figure 18, Page 21**).
4. Turn the bandsaw **ON**.
5. Slowly release the tension one quarter of a turn at a time. When you see the bandsaw blade start to flutter, stop decreasing the tension.

6. Now, slowly increase the tension until the blade stops fluttering, then tighten the tension another quarter turn.
7. Look at what the blade tension scale reads and use that as a guide for tensioning that blade in the future.

***Note:** Always release blade tension after use to increase blade life and reduce strain on the bandsaw components.*

8. Re-adjust the blade tracking as instructed on **Page 21**.

Adjusting Blade Guide Bearings

The blade guides provide side-to-side support to keep the blade straight while cutting. The blade guides are designed to be adjusted in two ways—forward/backward and side-to-side.

To adjust the upper blade guides:

1. Make sure the blade is tracking properly and that it is correctly tensioned.
2. **DISCONNECT BANDSAW FROM POWER!**



3. Familiarize yourself with the blade guide controls shown in **Figure 36 & 37**.

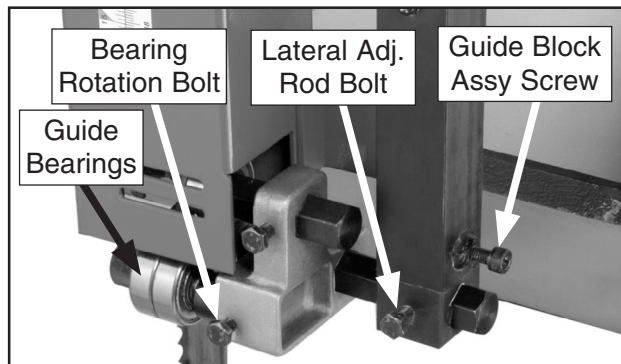


Figure 36. Upper blade guide controls (rear view).

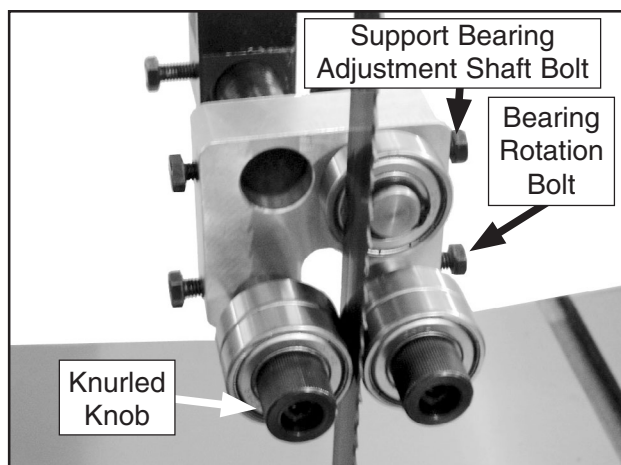


Figure 37. Upper blade guide controls (front view).

4. Loosen the lateral adjustment rod bolt, loosen the support bearing adjustment shaft bolt, and adjust the blade guides until the edges of the bearings are $\frac{1}{16}$ " behind the blade gullets, as illustrated in **Figure 38**.

Note: The $\frac{1}{16}$ " spacing is ideal, although with larger blades it may not be possible. In such cases, adjust the guide bearings as far forward to the blade gullets as possible, and still maintain the proper support bearing spacing adjustment.

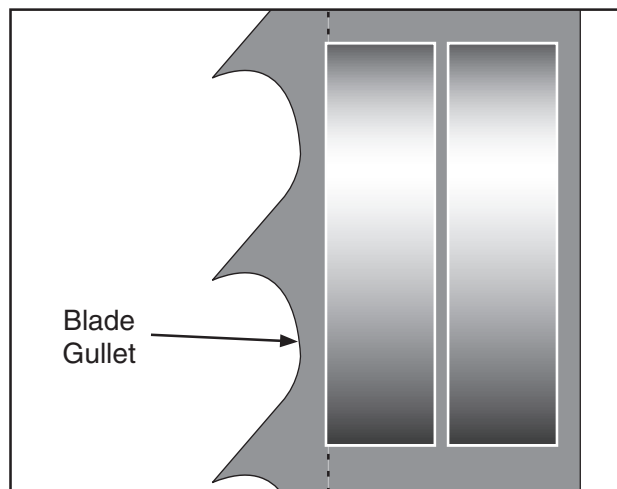


Figure 38. Lateral adjustment of blade guides.

NOTICE

Make sure that the blade teeth will not contact the guide bearings when the blade is against the rear support bearing during the cut or the blade teeth will be ruined.

5. Tighten the lateral adjustment rod bolt.
6. Loosen the bearing rotation bolts on both sides of the blade.
7. Rotate the knurled knobs to position the bearings 0.004" away from the blade.

Note: 0.004" is approximately the thickness of a dollar bill.

8. Tighten both of the the bearing rotation adjustment bolts to lock the blade guide bearings in position.

NOTICE

Whenever changing a blade or adjusting tension and tracking, the upper and lower blade support bearings and guide bearings must be properly adjusted and locked before cutting operations.



To adjust the lower blade guides:

1. Make sure the blade is tracking properly and that it is correctly tensioned.
2. DISCONNECT BANDSAW FROM POWER!
3. Familiarize yourself with the blade guide controls shown in **Figure 39**.

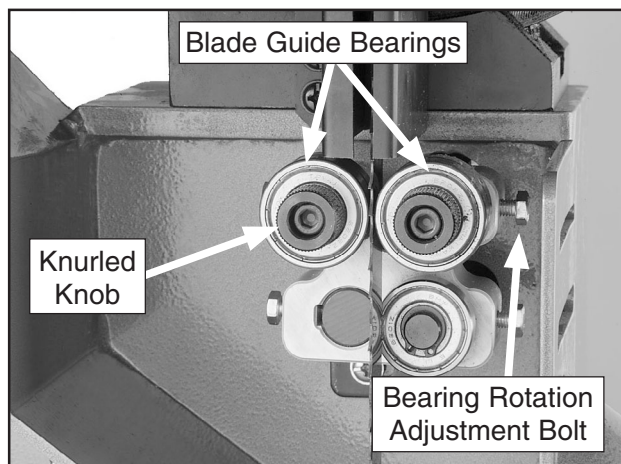


Figure 39. Lower blade guide controls (front view).

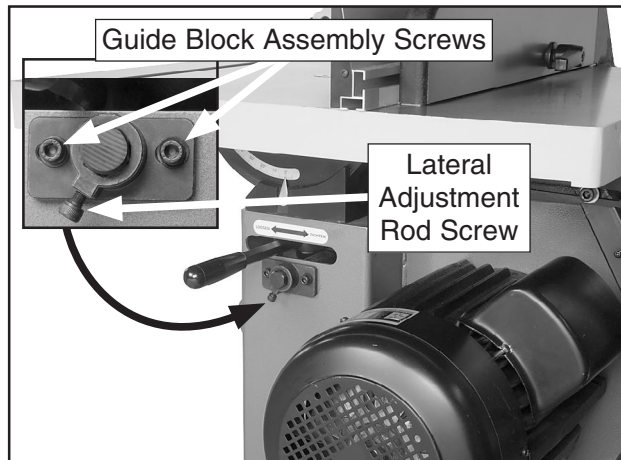


Figure 40. Lower blade guide controls (rear view).

4. Follow the procedure for adjusting the upper blade guides on **Page 30**.

Note: The lateral adjustment rod screw and guide block assembly screws are located below the table tilt lock lever (see **Figure 40**).

Adjusting Support Bearings

NOTICE

Whenever changing a blade or adjusting tension and tracking, the upper and lower blade support bearings and blade guide bearings must be properly adjusted before cutting operations.

The support bearings are positioned behind the blade for support during cutting operations. Proper adjustment of the support bearings is an important part of making accurate cuts and also keeps the blade teeth from coming in contact with the guide bearings while cutting.

To adjust the upper support bearing:

1. Make sure the blade is tracking properly and that it is correctly tensioned.
2. DISCONNECT BANDSAW FROM POWER!
3. Familiarize yourself with the upper support bearing controls shown in **Figure 36 & 37**.
4. Loosen the guide block assembly screw and rotate the blade guide assembly side-to-side, until the blade is perpendicular with the face of the support bearing, as illustrated in **Figure 41**.

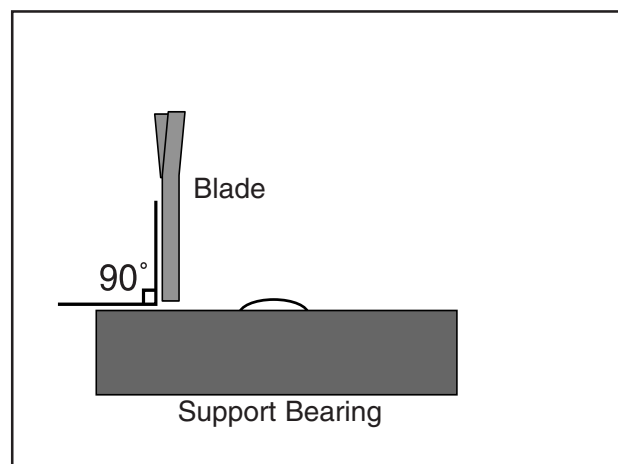


Figure 41. Illustration of blade set perpendicular (90°) to the support bearing face.



5. Tighten the guide block assembly screw.
6. Loosen the bolt on the support bearing adjustment shaft—if it is not already loose.
7. Using a feeler gauge between the support bearing and the blade, position the bearing 0.016" away from the back of the blade, as illustrated in **Figure 42**.

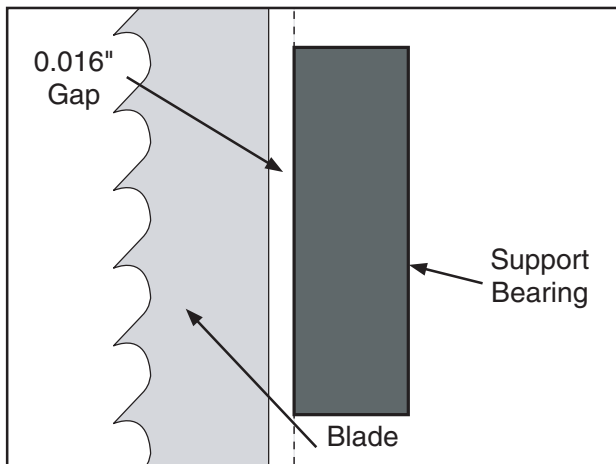


Figure 42. Blade aligned 0.016" away from the bearing edge.

Note: For a quick gauge, fold a crisp dollar bill in half twice (four thicknesses of a dollar bill is approximately 0.016") and place it between the support bearing and the blade as shown in **Figure 43**.

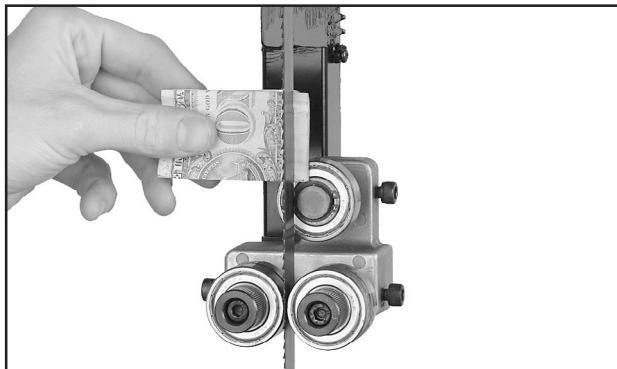


Figure 43. Example of dollar bill folded twice to make an approximate 0.016" gauge.

8. Tighten the bolt to keep the support bearing locked in place.

To adjust the lower support bearing:

1. Make sure the blade is tracking properly and is correctly tensioned.
2. DISCONNECT BANDSAW FROM POWER!
3. Familiarize yourself with the lower support bearing controls shown in **Figure 44**.

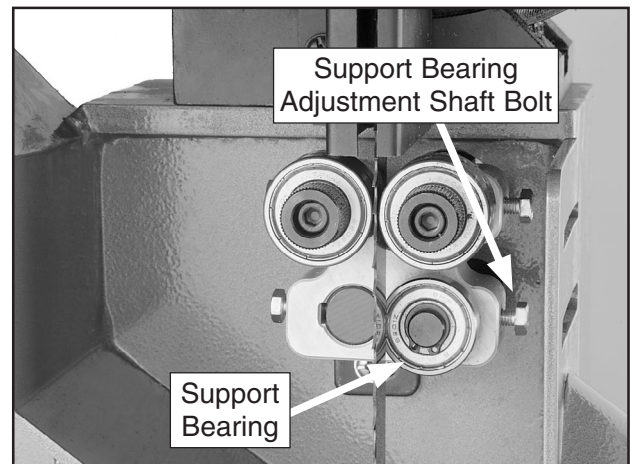


Figure 44. Lower support bearing controls.

4. Open the upper and lower wheel covers.
5. Make sure that the blade is perpendicular to the face of the support bearing, as illustrated in **Figure 41**.

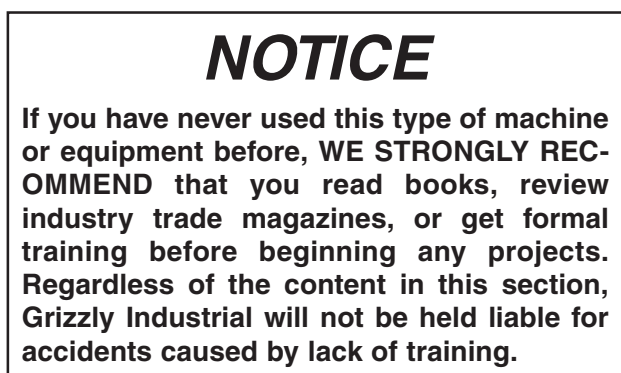
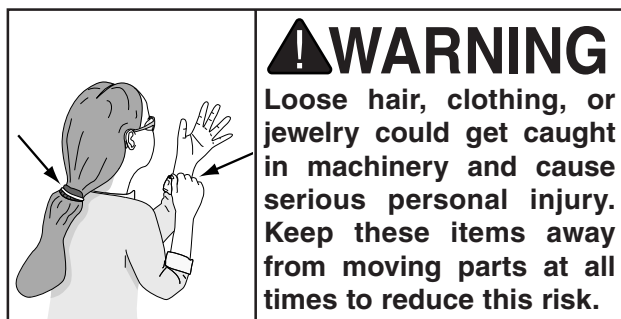
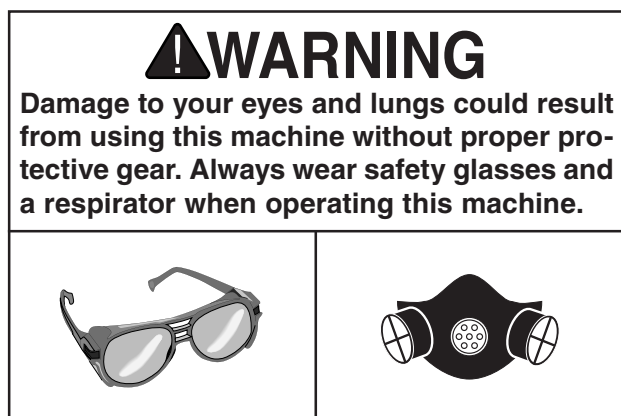
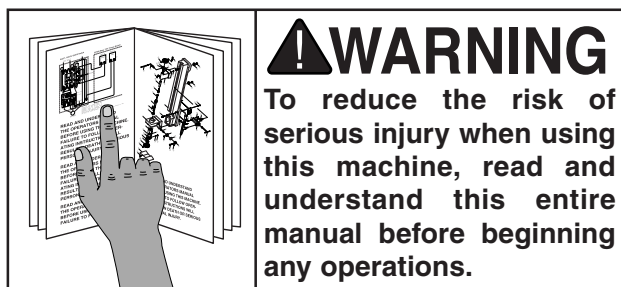
—If the blade is perpendicular to the face of the support bearing, continue on to the next step.

—If the blade is not perpendicular to the support bearing, loosen the lateral adjustment rod screw and guide block assembly screws (**Figure 40**) and rotate the assembly side-to-side until it is perpendicular to the face of the support bearing, then re-tighten the screws.

6. Loosen the bolt on the support bearing adjustment shaft.
7. Using a feeler gauge, position the bearing 0.016" away from the back of the blade, as illustrated in **Figure 42**, or use a dollar bill, as shown in **Figure 43**.
8. Tighten the bolt to keep the support bearing locked in place.



SECTION 4: OPERATIONS



Overview

The bandsaw is one of the most versatile wood cutting tools in the shop. It is capable of performing many different cutting functions including:

Straight Cuts

- Miters
- Angles
- Compound Angles
- Resawing
- Ripping
- Crosscutting

Irregular Cuts

- Simple and Complex Curves
- Duplicate Parts
- Circles
- Beveled Curves

A properly adjusted and tuned bandsaw can be safer to operate than most other saws and performs many functions with ease and accuracy.

Basic Cutting Tips

Here are some basic tips to follow when operating the bandsaw:

- Replace, sharpen, and clean blades as necessary and make adjustments periodically to keep the saw always running in top condition.
- Use light and even pressure while cutting. Light contact with the blade will permit easier line following and prevent undue friction.
- Avoid trying to turn tight corners because this will twist the blade. Remember, you must saw around corners.
- Misuse of the saw or using incorrect techniques is unsafe and results in frustration and poor cuts. Remember—the blade does the cutting with the operator's guidance.



Foot Brake

The Model G0568/G0569 is equipped with a foot brake (**Figure 45**). Use the brake only in emergency situations to disconnect power to the motor and bring the blade to a halt.

CAUTION

The foot brake will not stop the bandsaw wheels and blade instantly. **DO NOT** become over-confident and relax your safety awareness because of the foot brake feature.

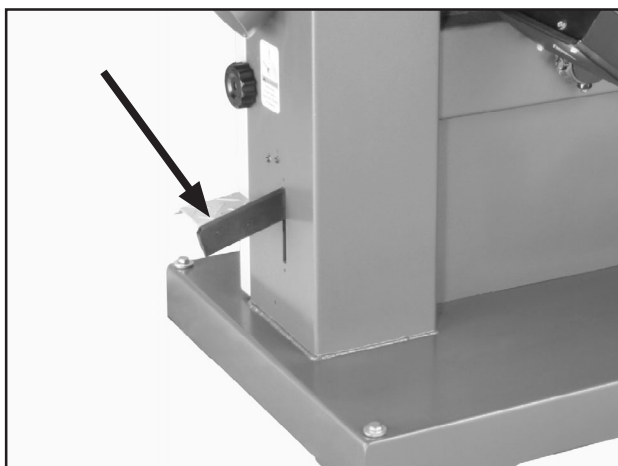


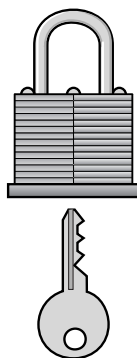
Figure 45. The foot brake is located below the dust collection port.

Key Switch

One of the most useful safety features of the Model G0568/G0569 is the key switch (**Figure 46**). To disable the ON and OFF controls turn the key to "0" and remove the key if desired. To enable the ON and OFF controls, turn the key to "1". The OFF button functions also as an emergency stop switch. If at any time during operation of the bandsaw a safety hazard present itself, immediately press the OFF button, or use the foot brake to bring the blade to a halt.



Figure 46. G0568/G0569 control panel.



CAUTION

Unsupervised children and visitors inside your shop could cause serious personal injury to themselves. Lock all entrances to the shop when you are away and **DO NOT** allow unsupervised children or visitors in your shop at any time!



Guide Post

The guide post, shown in **Figure 47**, connects the upper blade guide assembly to the bandsaw. The guide post allows the blade guide assembly to move up or down via a rack and pinion. In order to cut accurately, the blade guide assembly must be no more than 1" from the top of the workpiece at all times—this positioning provides the best support for the blade.

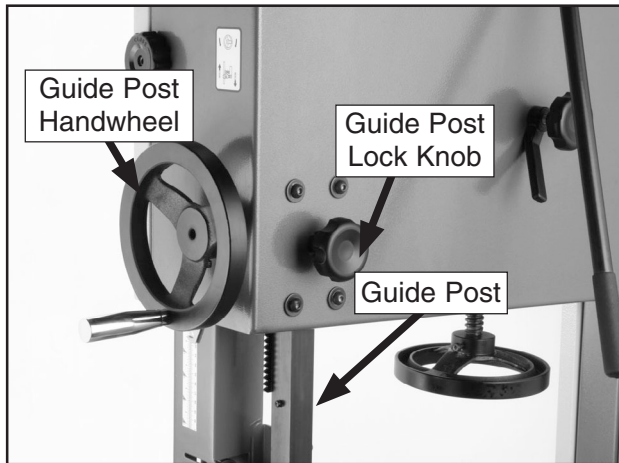


Figure 47. Guide post handwheel and lock knob.

To adjust guide post:

1. Make sure that the blade tension, blade tracking, support bearings, and blade guides are adjusted correctly.
2. Loosen the guide post lock knob shown in **Figure 47**.
3. Turn the guide post handwheel to raise or lower the guide post until the upper blade guide assembly is within 1" from the top of the workpiece.
4. Lock the guide post in place with the lock knob.

Ripping

Ripping is the process of cutting with the grain of the wood stock. For plywood and other processed wood, ripping simply means cutting down the length of the workpiece. For ripping, a wider blade is better. In most ripping applications, a standard raker tooth style will be sufficient.

To make a rip cut:

1. Adjust the fence to match the width of the cut on your workpiece and lock the fence in place.
2. Adjust the blade guide assembly to the correct height.
3. After all safety precautions have been met, turn the bandsaw **ON**. Slowly feed the workpiece into the blade and continue with the cut until the blade is completely through the workpiece. **Figure 48** shows a typical ripping operation. **Note:** *If you are cutting narrow pieces, use a push stick to protect your fingers.*



Figure 48. Example of typical ripping operation with a push stick.

⚠ WARNING

NEVER place fingers or hands in the line of cut. In the event that something unexpected happens, your hands or fingers may slip into the blade. **ALWAYS** use a push stick when ripping narrow pieces. Failure to follow these warnings may result in serious personal injury!



Crosscutting

Crosscutting is the process of cutting across the grain of wood. For plywood and other processed wood, crosscutting simply means cutting across the width of the material.

To make a 90° crosscut:

1. Mark the workpiece on the edge where you want to begin the cut.
2. Adjust the blade guide assembly to the correct height and make sure the miter gauge is set to 0°.
3. Move the fence out of the way. Place the workpiece evenly against the miter gauge.
4. Hold the workpiece against the miter gauge and line up the mark with the blade.
5. After all safety precautions have been met, turn the bandsaw **ON**. Slowly feed the workpiece into the blade and continue the cut until the blade is all the way through the workpiece. **Figure 49** shows a typical crosscutting operation.

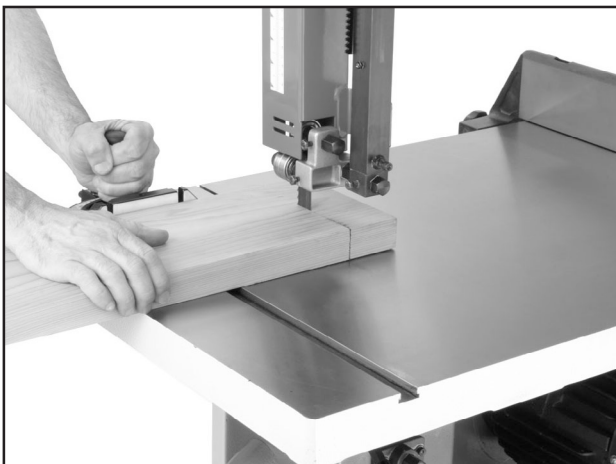


Figure 49. Example of crosscutting operation with miter gauge.

Resawing

Resawing (**Figure 50**) is the process of cutting a board into two or more thinner boards. The maximum board width that can be resawn is limited by the maximum cutting height of the bandsaw.

One of the most important considerations when resawing is blade selection. Generally, wider blades are better. In most applications, a hook or a skip tooth style will be desirable. Choose blades with fewer teeth-per-inch (from 3 to 6), because they offer larger gullet capacities for clearing sawdust, reducing heat buildup and reducing strain on the motor.

WARNING

When resawing thin pieces, a wandering blade (blade lead) can tear through the surface of the workpiece, exposing your hands to the blade teeth. Always use push blocks when resawing and keep your hands clear of the blade.

To resaw a workpiece:

1. Verify that the bandsaw is setup properly and that the fence is parallel to the blade.
2. Adjust the upper blade guide so it is about 1" above the workpiece with a minimum amount of blade exposed.
3. Install the optional Model H7528 resaw fence (see **Accessories, Page 43**), set it to the desired width of cut, and lock it in place.

NOTICE

The scale on the front rail will **NOT** be accurate when using the resaw fence.

4. Support the ends of the board if necessary.
5. Turn the bandsaw **ON**.
6. Using push paddles and a push stick, keep pressure against the fence and table, and slowly feed the workpiece into the moving blade until the blade is completely through the workpiece (see **Figure 50**).





Figure 50. Example of resawing lumber.

Cutting Curves

When cutting curves, simultaneously feed and turn the stock carefully so that the blade follows the layout line without twisting. If a curve is so abrupt that it is necessary to repeatedly back up and cut a new kerf, use either a narrower blade or a blade with more TPI (teeth per inch), or make more relief cuts.

Always make short cuts first, then proceed to the longer cuts. Relief cuts will also reduce the chance that the blade will be pinched or twisted. Relief cuts are cuts made through the waste portion of the workpiece and are stopped at the layout line. As you cut along the layout line, waste wood is released from the workpiece, alleviating any pressure on the back of the blade. Relief cuts also make backing the workpiece out easier, if needed.

NOTICE

The list below displays blade widths and the corresponding minimum radii for those blade widths.

Width	Radius
1/8"	1/8"
3/16"	3/8"
1/4"	5/8"
3/8"	1 1/4"
1/2"	2 1/2"
5/8"	3 3/4"
3/4"	5 1/2"

Blade Lead

It is common for a bandsaw blade to wander off the cut line when sawing as shown in **Figure 51**. This is called blade lead.

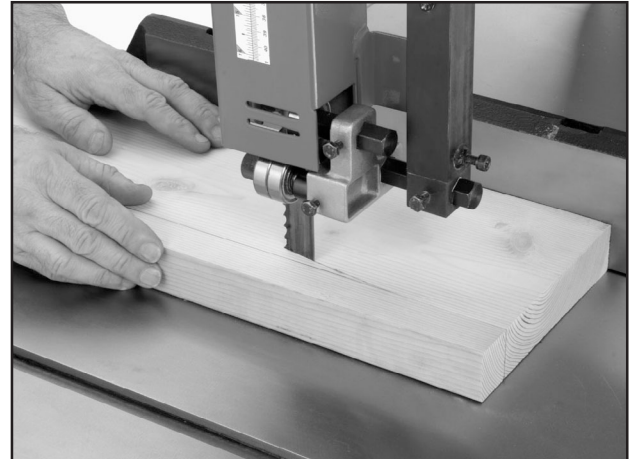


Figure 51. Blade leading away from line of cut.

To correct blade lead:

1. Check that the miter slot or fence is parallel to the blade line, and correct if necessary.
2. Check for proper blade tension. If the blade tension is correct and it is not convenient to replace the blade, compensate for lead by adjusting the table.

To shift the table:

1. On a scrap piece of wood, mark a line that is perpendicular to the front edge.
2. Cut the board on the line by pushing it into the blade with the miter gauge.
3. DISCONNECT BANDSAW FROM POWER!
4. Loosen the table mounting bolts. Shift the table to compensate for the blade lead.
5. Repeat **Steps 1-4** until the blade cuts straight.
6. Tighten the table bolts.



Table Tilt



The bandsaw table will tilt 5° left and 45° right to provide a wide range of cutting options.

To tilt the table:

1. DISCONNECT BANDSAW FROM POWER!
2. Loosen the table tilt lock lever shown in **Figure 52**.

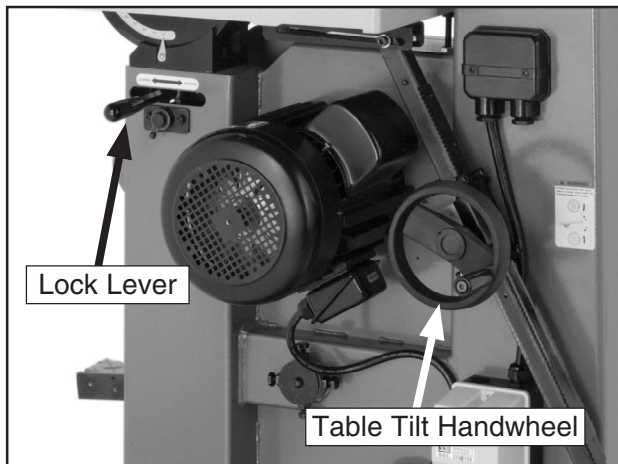


Figure 52. Table tilt controls.

3. To tilt the table to the right, turn the table tilt handwheel clockwise (**Figure 52**).
4. To tilt the table to the left, turn the table tilt handwheel clockwise one turn, lower the positive stop bolt, then turn the handwheel counterclockwise.
5. Secure the table tilt lock lever.
6. Follow "Positive Stop" instructions on **Page 26** for resetting the stop bolt and table for horizontal (0°) operations.

Stacked Cuts

One of the benefits of a bandsaw is its ability to cut multiple copies of a particular shape by stacking a number of workpieces together. Before making stacked cuts, ensure that both the table and the blade are properly adjusted to 90° (see **Page 26**). Otherwise, any error will be compounded.

To complete a stacked cut:

1. Align your pieces from top to bottom to ensure that each piece has adequate scrap to provide a clean, unhampered cut.
2. Secure all the pieces together in a manner that will not interfere with the cutting. Hot glue on the edges works well, as do brad nails through the waste portion. (Be careful not to cut into the brads or you may break the blade!)
3. On the face of the top piece, lay out the shape you intend to cut.
4. Make relief cuts perpendicular to the outline of your intended shape in areas where changes in blade direction could strain the woodgrain or cause the blade kerf to bind.
5. Cut the stack of pieces as though you were cutting a single piece. Follow your layout line with the blade kerf on the waste side of your line, as shown in **Figure 53**.

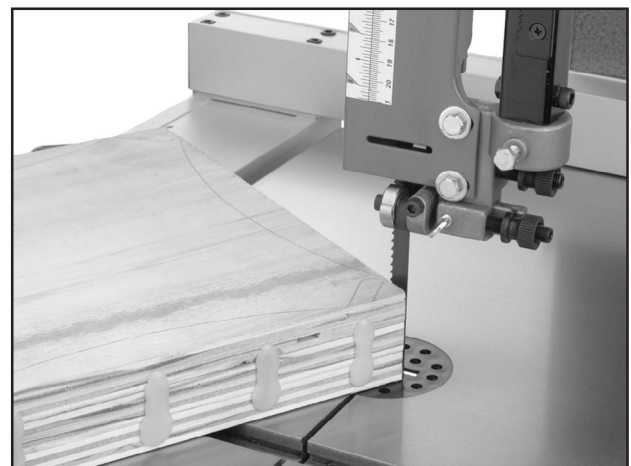


Figure 53. Typical stacked cut.



Blade Information

Selecting the right blade requires a knowledge of the various blade characteristics to match the blade with the particular cutting operation.

Blade Length

Measured by the circumference, blade lengths are usually unique to the brand of your bandsaw and the distance between wheels. The Model G0568/G0569 is designed for blades that are 179"–182" long. Refer to **Page 43** for blade replacements.

Blade Width

Measured from the back of the blade to the tip of the blade tooth (the widest point), blade width is often the first consideration given to blade selection. Blade width dictates the largest and smallest curve that can be cut, as well as how accurately it can cut a straight line.

The Model G0568/G0569 can use blades from $\frac{1}{4}$ " to $1\frac{1}{2}$ " in width. Always pick the size of blade that best suits your application.

- **Curve Cutting:** Use the chart in **Figure 54** to determine the correct blade for curve cutting. Determine the smallest radius curve that will be cut on your workpiece and use the corresponding blade width.

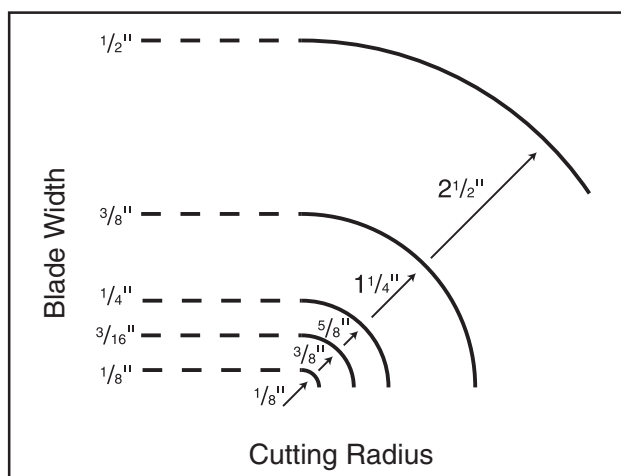


Figure 54. Blade width radii.

- **Straight Cutting:** Use the largest width blade that you own. Narrow blades can cut tight curves (a small radius) but are not very good at cutting straight lines because they naturally wander (blade lead). However, larger blades are much better at cutting straight lines, but function poorly at cutting small curves because of their size.

Tooth Style

When selecting blades, another option to consider is the shape, gullet size, teeth set and teeth angle—otherwise known as "Tooth Style." **Figure 55** shows the three main categories of tooth style:

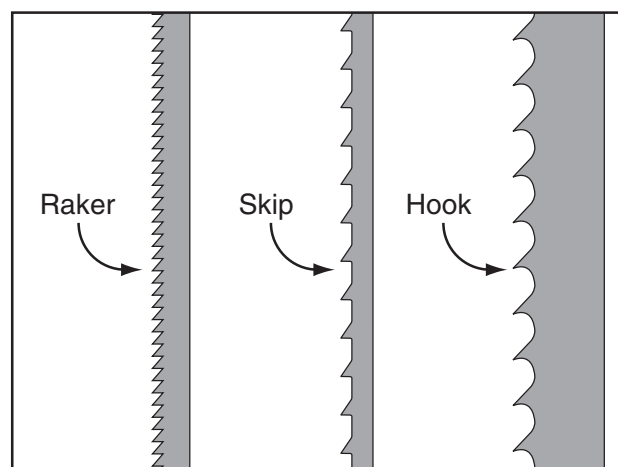


Figure 55. Raker, Skip & Hook tooth styles.

- **Raker:** This style is considered to be the standard because the tooth size and shape are the same as the tooth gullet. The teeth on raker blades usually are very numerous, have no angle, and produce cuts by scraping the material; these characteristics result in very smooth cuts, but do not cut fast and generate more heat while cutting.
- **Skip:** This style is similar to a raker blade that is missing every other tooth. Because of the design, skip toothed blades have a much larger gullet than raker blades, and therefore, cut faster and generate more heat. However, these blades also leave a rougher cut than raker blades.



- **Hook:** The teeth on this style have a positive angle (downward) which makes them dig into the material, and the gullets are usually rounded for easier waste removal. These blades are excellent for the tough demands of resawing and ripping thick material.

Tooth Pitch

Usually measured as TPI (teeth per inch), tooth pitch determines the size of the teeth. More teeth per inch (fine pitch) will cut slower, but smoother; while fewer teeth per inch (coarse pitch) will cut rougher, but faster. As a general rule, choose blades that will have at least three teeth in the material at all times. Use fine pitched blades on harder woods and coarse pitched blades on softer woods.

Blade Care

A bandsaw blade is a delicate piece of steel that is subjected to tremendous strain. You can obtain longer use from a bandsaw blade if you give it fair treatment and always use the appropriate feed rate for your operation.

Be sure to select blades with the proper width, style, and pitch for each application. The wrong choice of blades will often produce unnecessary heat which will shorten the life of your blade.

A clean blade will perform much better than a dirty blade. Dirty or gummed up blades pass through the cutting material with much more resistance than clean blades. This extra resistance also causes unnecessary heat.

Blade Breakage

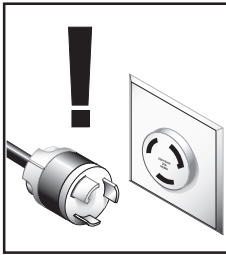
Many conditions may cause a bandsaw blade to break. Blade breakage is unavoidable, in some cases, since it is the natural result of the peculiar stresses that bandsaw blades are subjected to. Blade breakage is also due to avoidable circumstances. Avoidable breakage is most often the result of poor care or judgement on the part of the operator when mounting or adjusting the blade or support guides.

The most common causes of blade breakage are:

- Faulty alignment and adjustment of the guides.
- Forcing or twisting a wide blade around a curve of short radius.
- Feeding the workpiece into the blade too fast.
- Tooth dullness or absence of sufficient set.
- Incorrect tension.
- Top blade guide assembly set too high above the workpiece.
- Using a blade with a lumpy or improperly finished braze or weld.
- Continuously running the bandsaw when not in use.

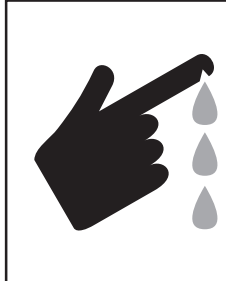


Blade Changes



⚠️ WARNING

Always disconnect power to the machine when changing blades. Failure to do this may result in serious personal injury.



⚠️ CAUTION

All saw blades are dangerous and may cause personal injury. To reduce the risk of being injured, wear leather gloves when handling saw blades.

To remove a blade:

1. DISCONNECT BANDSAW FROM POWER!
2. Release the blade tension.
3. Adjust the upper and lower guide bearings as far away as possible from the blade.
4. Open the upper and lower wheel covers, and with gloved hands, slide the blade off of both wheels.
5. Slide the blade through the slot in the table.

To replace a blade:

1. Slide the blade through the table slot, ensuring that the teeth are pointing forward and down toward the table.

Note: If the teeth will not point downward in any orientation, the blade is inside-out. Put on heavy gloves, remove the blade, and twist it right side-out.

2. Slip the blade through the guides, and mount it on the upper and lower wheels (**Figure 56**).

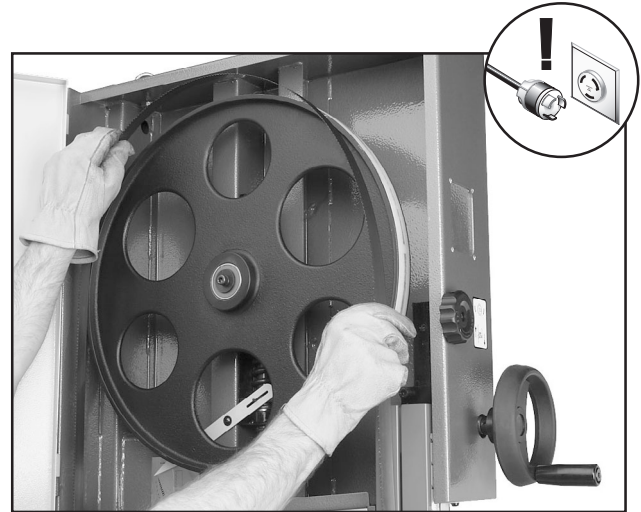


Figure 56. Example of placing blade on the wheels.

3. Adjust tension as described on **Page 30**.
4. Adjust tracking if needed (see **Page 21**).
5. Adjust the upper/lower guide bearings and the support bearings (see **Page 30**).
6. Close the wheel covers.



SECTION 5: ACCESSORIES

Replacement Blades

These replacement blades are milled for exact tooth set and are made with high quality tool steel.

180" Carbon Steel Replacement Blades for the Model G0568/G0569.

MODEL	WIDTH	TPI
H6988	1/2"	3 HOOK
G6989	1/2"	4 HOOK
H6990	1/2"	6 HOOK
H6991	1/2"	10 RAKER
H6992	1/2"	14 RAKER
H6993	1"	2 HOOK
H6994	1"	6 HOOK
H6995	1"	10 RAKER
H6996	1 1/4"	1.3 HOOK

180" Timber Wolf® Replacement Blades for the Model G0568/G0569.

MODEL	WIDTH	TPI
H8626	1/2"	3 POS. CLAW
H8627	1/2"	4 POS. CLAW
H8628	1/2"	6 POS. CLAW
H8629	1/2"	10 RAKER
H8630	1"	3 POS. CLAW
H8631	1"	4 POS. CLAW
H8632	1"	10 RAKER
H8633	1 1/4"	3/4" PITCH

Call 1-800-523-4777 To Order

G1094—Bandsaw Power Feeder with Fence, Single-Phase

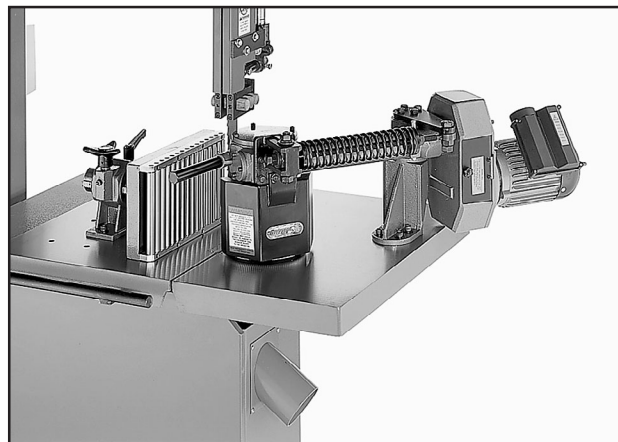


Figure 57. G1094 Bandsaw Power Feeder.

H7528— Re-Saw Fence Attachment

Our G0568/9 24" bandsaws already have a cast iron fence. This re-saw fence extrusion can be added to these bandsaws by simply drilling a hole through the fence for the rear bolt, which holds the extrusion against the shorter cast iron fence. Bolt and hardware is included.



Figure 58. H7528 Re-Saw Fence.



T20501—Face Shield Crown Protector 4"
T20502—Face Shield Crown Protector 7"
T20503—Face Shield Window
T20452—"Kirova" Anti-Reflective S. Glasses
T20451—"Kirova" Clear Safety Glasses
H0736—Shop Fox® Safety Glasses
H7194—Bifocal Safety Glasses 1.5
H7195—Bifocal Safety Glasses 2.0
H7196—Bifocal Safety Glasses 2.5



Figure 59. Eye protection assortment.

H4978—Deluxe Earmuffs - 27dB
H4979—Twin Cup Hearing Protector - 29dB
T20446—Ear Plugs 200 Pair - 31dB
 Protect your hearing before its too late. Especially important if you or employees operate for hours at a time.



Figure 60. Hearing protection assortment.

H2499—Small Half-Mask Respirator
H3631—Medium Half-Mask Respirator
H3632—Large Half-Mask Respirator
H3635—Cartridge Filter Pair P100
 Wood dust has been linked to nasal cancer and severe respiratory illnesses. If you work around-dust everyday, a half-mask respirator can be a lifesaver. Also compatible with safety glasses!



Figure 61. Half-mask respirator with disposable cartridge filters.

G5562—SLIPIT® 1 Qt. Gel
G5563—SLIPIT® 12 oz Spray
G2871—Boeshield® T-9 12 oz Spray
G2870—Boeshield® T-9 4 oz Spray
H3788—G96® Gun Treatment 12 oz Spray
H3789—G96® Gun Treatment 4.5 oz Spray



Figure 62. Recommended products for protecting unpainted cast iron/steel on machinery.

Call 1-800-523-4777 To Order



G1163—1HP Dust Collector

Effective dust collection not only keeps your shop cleaner and more pleasant to work in, it can also keep you healthier. Our systems feature powerful motors and convenient collection bags - so they're ideal for just about any-sized woodworking operation.



Figure 63. G1163 1HP dust collector.

G1928—Bandsaw Handbook

This is the bandsaw bible. Covers step-by-step instructions for basic/advanced cutting techniques. Also includes advanced maintenance, service and troubleshooting procedures, as well as information on bandsaw history/design and blade metallurgy. 320 pages.

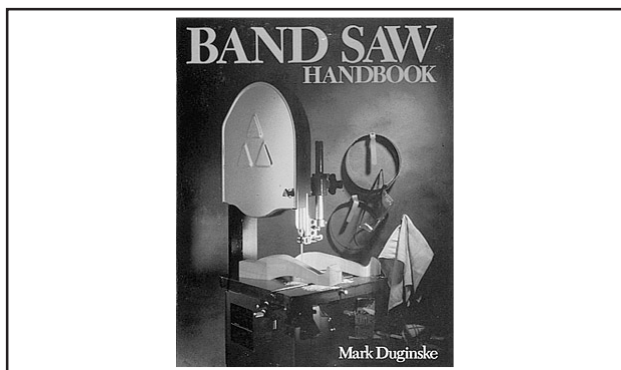


Figure 64. Bandsaw handbook.

H2993—4-Pc Machinist Square Set

This is a handy set to have around. Each square is finely ground stainless steel. All have common beam and blade widths and thicknesses which will allow them to be used in combination. 2", 3", 4" & 6" squares.

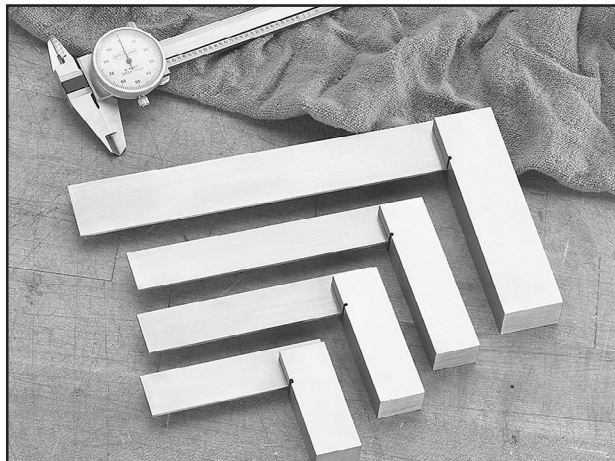


Figure 65. H2993 4-Pc. Square Set.

H7529—Complete Re-saw Fence

Designed by us here at Grizzly, these new re-saw fences are an upgrade to the standard fences and allow users to alternate between a taller and shorter fence within seconds. The removable extruded re-saw fence allows you to lower the blade guides closer to the shorter fence for doing normal work. These fences can be purchased as a retrofit kit for existing Grizzly bandsaws as well as a complete fence system for just about any brand of saw with proper table dimensions. Patent Pending! This is a complete fence unit that includes the shorter cast iron fence as well as the taller re-saw fence.



Figure 66. H7529 Re-Saw Fence.



H1052—Clear Flexible Hose 4" x 10'
G1536—Black Flexible Hose 4" x 10'
G3179—Heavy-Duty Clear Flex Hose 4" x 10'
G8830—Hose Hanger 4½"
G1552—Y-Fitting 4" x 4" x 4"
G1545—90° Elbow 4"
G2482—Hose Coupler (Splice) 4"
G2974—Wire Hose Clamp 4"
G1843—Plastic Blast Gate 4"
G4679—Anti-Static Grounding Kit

We've hand picked a selection of commonly used dust collection components for machines with 4" dust ports.



Figure 67. Dust collection accessories.

H7874—Ceramic Guide Set for 21" & 24" Bandsaws

Euro-style ceramic guides run cooler and are extremely wear resistant compared to standard ball bearing guides. Fits G0568 and G0569 bandsaws. Set includes both upper and lower guides.

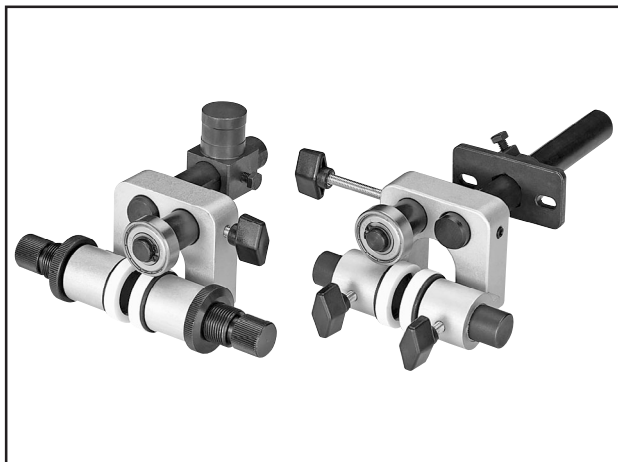


Figure 68. H7874 Ceramic Guide Set.

G7315—Super Heavy-Duty SHOP FOX® Mobile Base

This patented, super heavy-duty mobile machine base is the strongest mobile base on the market. 18" x 24½" minimum and adjusts to 28½" x 33½" maximum. 1200 lb. capacity. This base is extremely stable with outrigger type supports and a four wheel system. Weighs 61 lbs.

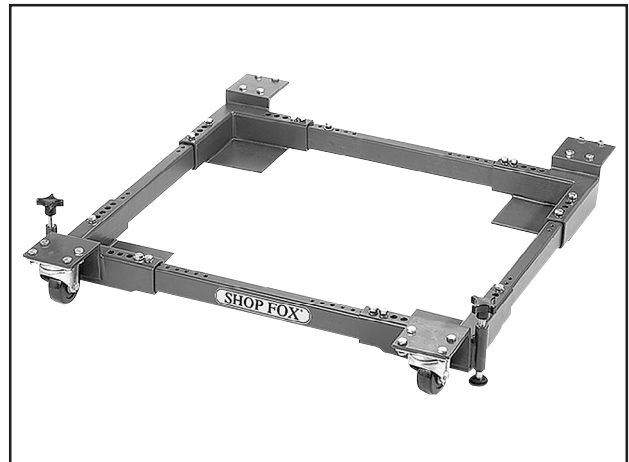


Figure 69. G7315 SHOP FOX® Mobile Base.

G8685—Extension Bars for Super Heavy-Duty SHOP FOX® Mobile Base

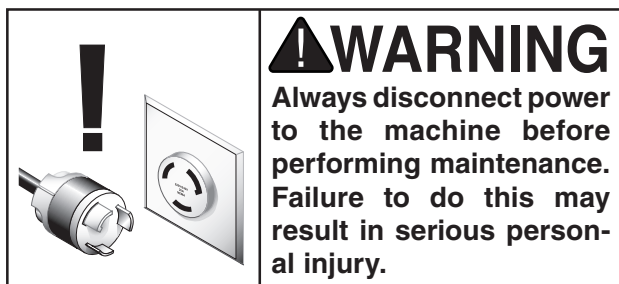
These 36" extension bars replace the standard length side rails on the G7315 Super Heavy-Duty Mobile Base. This allows the base to be assembled with a minimum capacity of 18" x 34" to a maximum capacity of 28½" x 44", suitable for heavier and longer machines such as lathes. Sold in pairs.



Figure 70. G8685 Extension Bars.



SECTION 6: MAINTENANCE



Schedule

For optimum performance from your machine, follow this maintenance schedule and refer to any specific instructions given in this section.

Daily Check:

- Loose mounting bolts.
- Damaged saw blade.
- Worn or damaged wires.
- Any other unsafe condition.

Monthly Check:

- V-belt tension, damage, or wear.
- Clean/vacuum dust buildup from inside cabinet and off motor.

Cleaning

Cleaning the Model G0568/G0569 is relatively easy. Vacuum excess wood chips and sawdust, and wipe off the remaining dust with a dry cloth. If any resin has built up, use a resin dissolving cleaner to remove it. Treat all unpainted cast iron and steel with a non-staining lubricant after cleaning.

Unpainted Cast Iron

Protect the unpainted cast iron surfaces on the table by wiping the table clean after every use—this ensures moisture from wood dust does not remain on bare metal surfaces.

Keep tables rust-free with regular applications of products like G96® Gun Treatment, SLIPIT®, or Boeshield® T-9 (see **Section 5: Accessories** on **Page 43** for more details).

Brushes

The bandsaw is equipped with three lower brushes. The brushes should be checked daily and cleaned when they become dirty. There are adjustment brackets that allow the brushes to be adjusted for bristle wear. Refer to **Adjusting Wheel and Blade Brushes** on **Page 55** for adjustment details.

Lubrication

Sealed and pre-lubricated ball bearings require no lubrication for the life of the bearings. All bearings are standard sizes, and replacements can be purchased from our parts department or a bearing supply store.

Most other moving parts need to be lubricated as needed to maintain smooth function of the bandsaw.



To lubricate the blade guide rack and pinion:

1. DISCONNECT BANDSAW FROM POWER!
2. Lower the blade guide until it reaches the table.
3. Wipe off any existing grease and sawdust buildup on the rack (**Figure 71**)



Figure 71. Example of rack lubrication location.

4. Apply a thin coat of light all-purpose grease to the rack.
5. Move the blade guide up and down several times and remove any excess grease to help prevent sawdust buildup.

To lubricate the blade tracking knob:

1. DISCONNECT BANDSAW FROM POWER!
2. Unscrew the blade tracking knob 5 turns.
3. Wipe off any existing grease and sawdust buildup on the threads.
4. Apply a few dabs of a light all-purpose grease to the threads.
5. Re-adjust tracking (see **Blade Tracking** on **Page 21**).

To lubricate the tension adjustment assembly:

1. DISCONNECT BANDSAW FROM POWER!
2. Open the top wheel cover and look through the top of the wheel.
3. Wipe off any existing grease and sawdust buildup on the blade tension adjustment assembly and tension lever cam.
4. Apply a thin coat of grease to the tension adjustment assembly and tension lever cam (**Figure 72**).

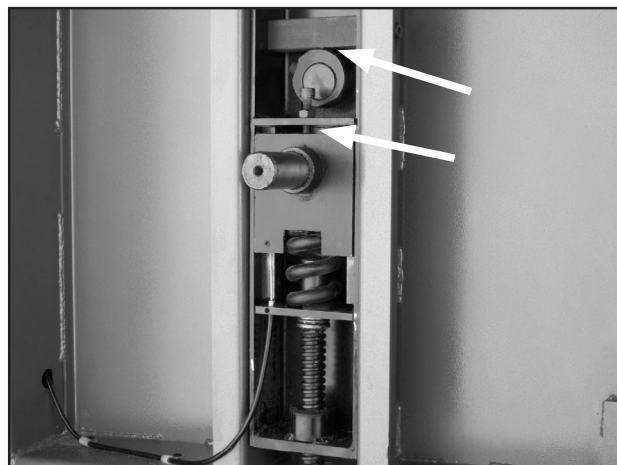


Figure 72. Tension adjustment assembly locations (top wheel removed for clarity).



To lubricate the table tilt rack and pinion assembly:

1. DISCONNECT BANDSAW FROM POWER!
2. With the table perpendicular to the blade, wipe off all existing grease and sawdust buildup from the rack.
3. Move the table up to its maximum 45° angle and wipe (**Figure 73**) off all existing grease and sawdust buildup from the rack.

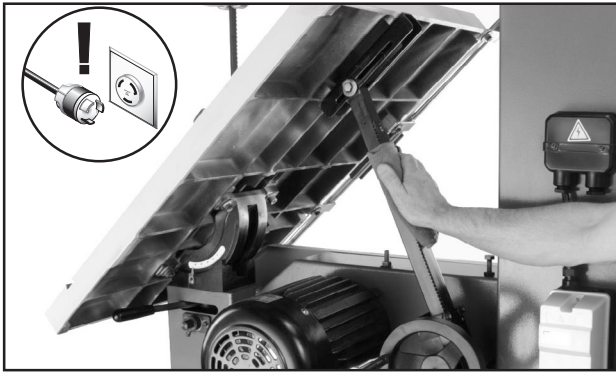


Figure 73. Example of lubricating table tilt rack and pinion assembly.

4. Apply a thin coat of light all-purpose grease to the rack.
5. Move the table up and down several times to distribute the grease, then wipe off any excess grease.

To lubricate the trunnions:

1. DISCONNECT BANDSAW FROM POWER!
2. Move the table up until it reaches its maximum 45° angle and wipe off all excess grease and sawdust from the trunnions.
3. Apply a thin coat of light all purpose grease to the trunnions (**Figure 74**).

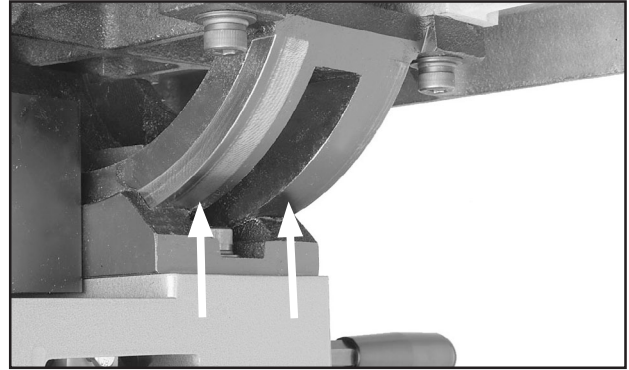


Figure 74. Trunnion lubrication location.

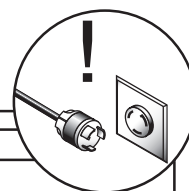
4. Move the table down and then back up to distribute the grease, then wipe off any excess grease from the trunnions.



SECTION 7: SERVICE

Review the troubleshooting and procedures in this section to fix or adjust your machine if a problem develops. If you need replacement parts or you are unsure of your repair skills, then feel free to call our Technical Support at (570) 546-9663.

Troubleshooting



Symptom	Possible Cause	Possible Solution
Machine does not start.	<ol style="list-style-type: none"> Emergency stop button engaged/at fault. Switch disabling key removed. Door safety switch disengaged/at fault. Thermal overload relay in mag switch tripped. Break or short in wiring; or loose or corroded connections. Plug or receptacle is corroded or miswired. Power supply switched off/has incorrect voltage. Motor connection wired incorrectly. Contactor has poor contacts or is at fault. Blown fuse/tripped circuit breaker. Motor ON/OFF switch at fault. Start capacitor has blown. Centrifugal switch at fault. Motor at fault. 	<ol style="list-style-type: none"> Rotate button to reset/replace button. Reinstall switch disabling key. Close door or adjust/replace switch. Allow relay/motor to cool. If necessary, press reset button inside switch. Trace/replace broken or corroded wires; fix loose connections. Correct the wiring. Switch power supply on/verify voltage. Wire motor correctly. Refer to inside junction box cover or Page 62 (G0568) or Page 63 (G0569). Test all legs for power, test field coil, and fix contacts or replace if at fault. Replace/reset fuse or circuit breaker. Repair possible short or circuit overload. Replace switch. Test/replace if at fault. Adjust/replace centrifugal switch. Test for shorted windings or bad bearings; repair or replace.
Main motor chatters during startup or during operation.	<ol style="list-style-type: none"> Phase converter (if used) wild wire connected to wrong terminal(G0569). Power supply has incorrect voltage on one or more legs. 	<ol style="list-style-type: none"> Connect wild wire to the machine power supply terminal that is not part of the switch coil circuit (G0569). Contact electrician to check incoming voltage (G0568).
Machine operates in reverse.	<ol style="list-style-type: none"> Power connections wired out of phase (G0569). 	<ol style="list-style-type: none"> Swap two power incoming power leads at the motor (G0569).



Symptom	Possible Cause	Possible Solution
Machine has excessive vibration or noise.	<ol style="list-style-type: none"> 1. V-belt tension incorrect. 2. Bent, dull, or damaged blade. 3. Loose or damaged blade. 4. Blade weld contacting support bearing or blade guides. 5. Loose machine component. 6. Machine incorrectly mounted on floor. 7. Phase converter (if used) wild wire connected to wrong terminal(G0569). 8. Motor fan rubbing on fan cover. 9. V-belt worn or damaged. 10. Wheels not coplanar. 11. V-belt has a high spot. 12. Centrifugal switch out of adjustment; at fault. 13. Pulley loose or not in alignment; shaft bent. 14. Worn wheel bearing. 15. Wheel tires worn or incorrectly installed. 16. Wheels out of balance. 17. Motor bearings worn or damaged. 	<ol style="list-style-type: none"> 1. Tighten V-belt. See Page 54. 2. Replace blade (Page 42). 3. Tighten or replace blade. 4. Use file or stone to smooth and round the back of the blade. 5. Tighten loose component. 6. Level/shim base; tighten/adjust mounting hardware or feet. 7. Connect wild wire to the machine power supply terminal that is not part of the switch coil circuit (G0569) 8. Fix/replace fan cover; replace loose or damaged fan. 9. Replace V-belt. (Use link belts if possible.) See Page 55. 10. Adjust wheels coplanar (Page 59). 11. Replace/adjust the V-belt (Page 55). 12. Adjust/replace centrifugal switch. 13. Replace worn pulley, key, and shaft, and realign. 14. Check/replace wheel bearing. 15. Replace or re-install tires. 16. Replace wheels. 17. Replace motor bearings or replace motor.
Machine stalls or slows when operating.	<ol style="list-style-type: none"> 1. Too much pressure when feeding workpiece. 2. Workpiece too moist or material not suitable for machine. 3. Workpiece is warped. 4. Fence incorrectly adjusted. 5. Belt(s) slipping. 6. Run capacitor at fault. 7. Motor connection wired incorrectly. 8. Motor is wired out of phase (G0569). 9. Motor overheated. 10. Contactor has poor contacts or is at fault. 11. Centrifugal switch at fault. 12. Motor at fault. 	<ol style="list-style-type: none"> 1. Reduce pressure when feeding workpiece. 2. Only cut wood and ensure moisture is below 20%. 3. Straighten workpiece or use a different one. 4. Adjust/calibrate fence. 5. Tension/replace belt(s); ensure pulleys are aligned. 6. Test/repair/replace. 7. Review wiring diagram on motor cover; correct wire connections. 8. Swap any two incoming power leads. 9. Let cool, clean motor, and reduce workload. 10. Test all legs for power, test field coil, and fix contacts or replace if at fault. 11. Adjust/replace centrifugal switch if available. 12. Test for shorted windings, bad bearings and repair or replace.
Miter bar binds in miter slot.	<ol style="list-style-type: none"> 1. Miter slot dirty or gummed up. 	<ol style="list-style-type: none"> 1. Carefully clean miter slot.
Table does not tilt to 90 degrees.	<ol style="list-style-type: none"> 1. Pointer or scale calibrated incorrectly. 2. Positive stop bolt not set correctly. 	<ol style="list-style-type: none"> 1. Calibrate pointer/scale at true 90 degrees (Page 26). 2. Adjust positive stop bolt.
Table does not tilt to 45 degrees.	<ol style="list-style-type: none"> 1. Pointer or scale calibrated incorrectly. 2. Machine component blocking path. 	<ol style="list-style-type: none"> 1. Calibrate pointer/scale at true 45 degrees. 2. Remove component blocking table.



Symptom	Possible Cause	Possible Solution
Table hard to tilt.	<ol style="list-style-type: none"> 1. Sawdust or pitch trapped between trunnion and base. 2. Metal burrs on trunnion. 	<ol style="list-style-type: none"> 1. Calibrate pointer/scale at true 45 degrees. 2. Remove burrs.
The cuts are rough, or show scoring.	<ol style="list-style-type: none"> 1. Blade is overloaded and twists. 2. The blade TPI is too coarse. 3. The blade is loose and slipping on wheels. 4. Blade tracking is incorrect. 5. The blade has missing or bent teeth. 6. The blade has a faulty weld. 	<ol style="list-style-type: none"> 1. Decrease the feed rate. 2. Use the correct blade for material and speed of cut. 3. Adjust bade tension as required. 4. Adjust the blade tracking back to normal. 5. Replace the blade (Page 42). 6. Replace the blade (Page 42).
Blade or teeth break often.	<ol style="list-style-type: none"> 1. Blade tension is incorrect. 2. Incorrect blade for application. 3. The feed is too heavy or blade speed is wrong. 4. Cutting corners too sharply. 5. Blades used when dull. 6. Blade tracking is wrong. 7. Blade guide adjustment at fault. 8. Inadequate blade support. 9. Blade welds at fault. 10. Wheel tires worn or incorrectly installed. 11. Fence or miter slot out of alignment with blade. 	<ol style="list-style-type: none"> 1. Adjust blade tension (Page 30). 2. Use correct blade for application. 3. Reduce feed rate or increase blade speed (Page 34). 4. Use a wider arc on outside cuts, or use relief cuts to make tight inside cuts. 5. Replace the blade (Page 42). 6. Adjust the blade tracking back to normal (Page 21). 7. Adjust blade guide bearings for correct blade support. 8. Adjust upper blade guide so it is as close as possible to workpiece. 9. Replace with blade from different manufacturer (Page 42). 10. Replace or re-install tires. 11. Align table miter slot and fence with blade (Page 27).
Blade wears on one side, slows, smokes or shows overheating.	<ol style="list-style-type: none"> 1. Blade contacting table insert. 2. The blade guides are worn or mis-adjusted. 3. The blade has insufficient support. 4. Blade is installed backwards. 5. Blade spinning backwards due to out of phase wiring (3-phase only, G0569). 6. Too much side pressure when feeding workpiece. 7. The wheels are out of alignment. 8. Dull or incorrect blade. 9. Blade is bell-mouthed. 10. Fence not parallel with blade (pressure at blade backside). 11. Table top surface is not parallel or square to blade. 	<ol style="list-style-type: none"> 1. Adjust blade guide bearings to eliminate excess side pressure. Adjust table for correct blade clearance and miter slot alignment. 2. Tighten the blade guide bracket. 3. Tighten the blade guide as close to the workpiece as possible. 4. Check blade rotation as described in Test Run" and reverse blade if necessary. 5. Switch two of the current carrying wires at the terminal strip. 6. Feed workpiece straight into the blade. 7. Adjust the wheels so they are coplanar (Page 59). 8. Replace blade (Page 42). 9. Install new blade. 10. Adjust fence parallel with blade (Page 28). 11. Adjust/shim table/trunnion position until blade and table are parallel and square.
Sawdust buildup inside cabinet.	<ol style="list-style-type: none"> 1. Clogged dust port. 2. Low CFM (airflow) from dust collection system. 	<ol style="list-style-type: none"> 1. Clean out dust port. 2. Repair ducting for leaks or clogs, move dust collector closer to machine, install a stronger dust collector.



Symptom	Possible Cause	Possible Solution
Blade tracks incorrectly, or comes off wheels.	<ol style="list-style-type: none"> 1. Tracking is not adjusted properly. 2. Wheels are not coplanar. 3. Blade tension is too loose. 4. Blade guides need adjustment. 5. Feeding workpiece too fast. 6. Incorrect blade for bandsaw. 7. Blade is bell-mouthed, worn or dull. 8. Rubber tire on wheel is damaged or worn. 	<ol style="list-style-type: none"> 1. Adjust tracking (Page 21). 2. Adjust wheel coplanarity (Page 59). 3. Increase blade tension (Page 30). 4. Adjust blade guides (Page 30). 5. Feed workpiece slower (Page 34). 6. Install correct blade for machine. 7. Install new blade, and de-tension blade when not in use. 8. Replace rubber tires.
The cut is crooked, or the blade wanders (blade lead).	<ol style="list-style-type: none"> 1. The feed pressure is too high or the blade speed is wrong. 2. The blade tension is low. 3. The blade is dull or damaged. 4. Inadequate blade support. 5. Incorrect blade for application. 6. The blade tracking is wrong. 7. Table is loose. 8. Fence or miter slot out of alignment with blade. 9. Blade guide alignment at fault. 	<ol style="list-style-type: none"> 1. Adjust feed rate and cutting speed as required. 2. Increase the blade tension (Page 30). 3. Replace the blade (Page 42). 4. Adjust upper blade guide so it is as close as possible to workpiece (Page 30). 5. Use wider blade. 6. Adjust the blade tracking back to normal. 7. Tighten table trunnion mounting bolts or tilt lock lever. 8. Align table miter slot and fence with blade. 9. Adjust blade guide bearings for correct blade support.



Checking and Tensioning V-Belts

To ensure optimum power transmission from the motor to the blade, the V-belts must be in good condition and operate under proper tension. The belts should be checked for cracks, fraying, and wear. Belt tension should be checked at least every 3 months—more often if the bandsaw is used daily.

Tools Needed:

	Qty
Ruler	1
Hex Wrench 6mm	1
Wrench 13mm	1

To check the V-belts:

1. DISCONNECT BANDSAW FROM POWER!
2. Open the wheel covers.
3. Note the condition of the V-belts. If the V-belts are cracked, frayed, or glazed; they should be replaced.
4. Push the center of the V-belts. Note the amount of deflection (**Figure 75**). If deflection is more than $\frac{3}{4}$ ", tension the V-belt.

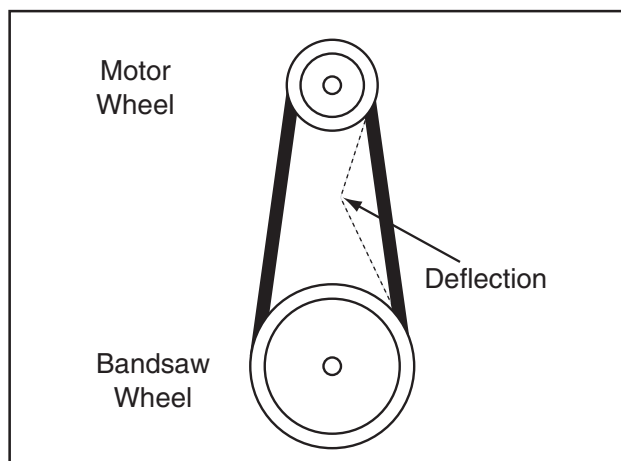


Figure 75. V-belt deflection.

To tension the V-belts:

1. DISCONNECT BANDSAW FROM POWER!
2. Open the wheel covers.
3. Loosen the motor adjustment bolts shown in **Figure 76**.

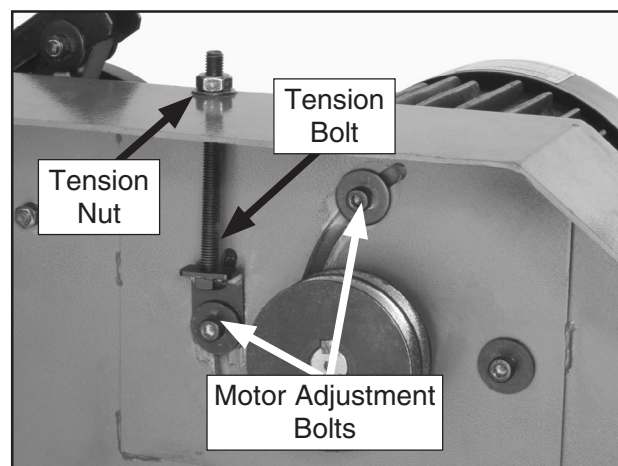


Figure 76. Motor mount bolts and tension bolt.

4. Adjust the belt tension:
 - If the belt is too loose, turn the tension nut clockwise to tighten the belts.
 - If the belt is too tight, turn the tension nut counterclockwise to loosen the belts
5. Push the center of the V-belt. If deflection is approximately $\frac{3}{4}$ " with moderate pressure, then the tension is correct. If the deflection is more than $\frac{3}{4}$ ", repeat **Step 4**.
6. When the V-belt tension is correct, tighten the motor adjustment bolts, and close the wheel covers.



Replacing V-Belt

Tools Needed:	QTY
Hex Wrench 6mm.....	1
Wrench 13mm	1

To replace the V-belt:

1. DISCONNECT BANDSAW FROM POWER!
2. Open the wheel covers and remove the bandsaw blade.
3. Loosen the motor mount bolts shown in **Figure 76**, then turn the tension bolt counter-clockwise, and pull the V-belts off.
4. Unthread the wheel cap screw shown in **Figure 77** and slide the lower wheel off of the bearing shaft.

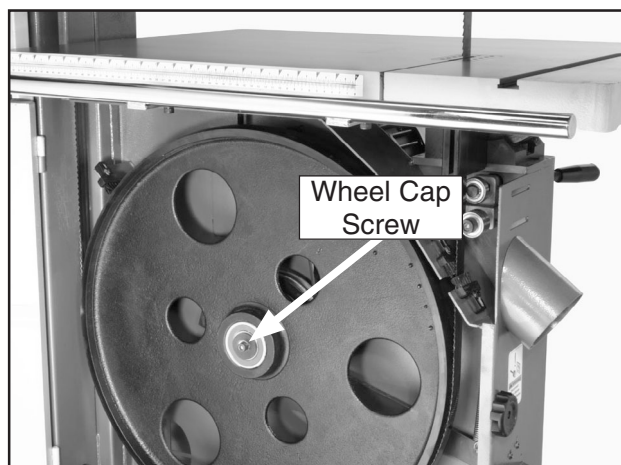


Figure 77. Wheel cap screw for removing the wheel.

5. Slip the old V-belts off of the wheel pulley and install the new V-belts in their place.
6. Install the lower wheel back onto the bearing shaft, tighten the wheel mount bolt, place the V-belts over the motor pulley, and turn the tension bolt clockwise to tighten the V-Belt tension.
7. When the tension is correct, tighten the motor hinge bolt and close the lower wheel cover.

Adjusting Wheel and Blade Brushes

The lower wheel compartment contains the brushes shown in **Figure 78**. These brushes are designed to sweep sawdust off the wheel tire and blade as the bandsaw is operating. In order to work properly, the brushes must be making contact with the wheel and blade.

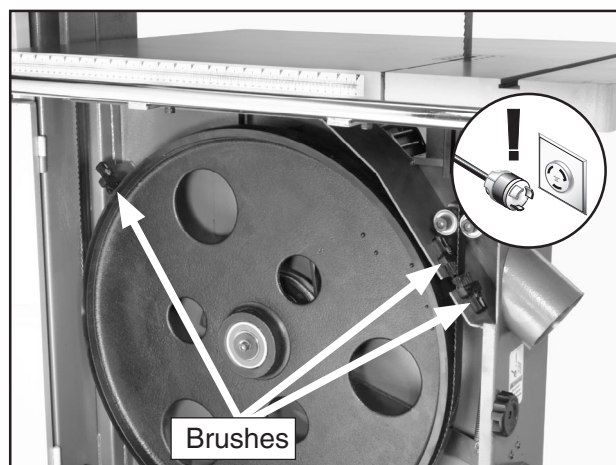


Figure 78. The wheel brush.

Tools Needed:	Qty
Wrench/Socket 10mm	2

To adjust the brushes:

1. DISCONNECT BANDSAW FROM POWER!
2. Open the lower wheel cover.
3. Loosen the bolt/nut that secures each brush in place.
4. Adjust each brush so it makes good contact with the wheel or blade—without bending the bristles.
5. Tighten the bolt/nuts to secure each brush in place.



Adjusting Tension Lever

The quick release tension lever is setup correctly for use with the preinstalled 181" blade. However, if you install a different length blade, you will need to adjust the tension lever adjustment screw so the quick release tension lever works correctly.

Tools Needed:	Qty
Hex Wrench 6mm.....	1
Wrench 13mm	2

To adjust the tension lever:

1. DISCONNECT BANDSAW FROM POWER!
2. Open the wheel covers, remove the bandsaw blade, then install the new one (refer to **Blade Changes** on **Page 42**).
3. Loosen the jam nut on the tension adjustment screw 7-10 turns.
4. Put the quick release tension lever in the down (engaged) position, then turn the blade tension handwheel until the blade tension matches the mark on the blade tension scale for the appropriate blade thickness.
5. Thread the tension adjustment screw (**Figure 1**) down until it contacts the wheel block plate, then back it off 1-2 turns.

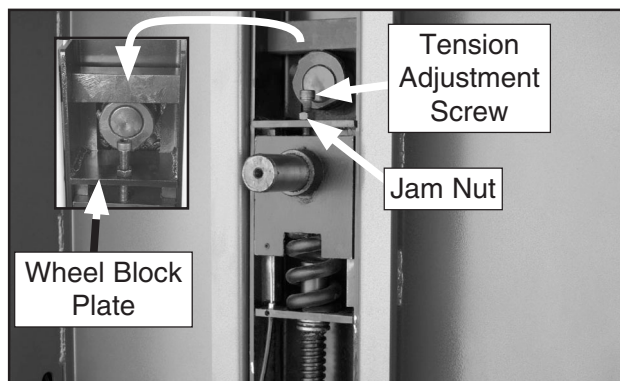


Figure 1. Example of quick release tension lever adjustment screw.

6. Tighten the jam nut.

Adjusting Guide Post Travel

The guide post assembly should remain parallel with the blade front-to-back and side-to-side along its length of travel. If it does not, follow these instructions to correctly adjust the guide post.

Tools Needed:

Machinist's Square	1
Small Fine Ruler.....	1
Hex Wrench 5mm.....	1
Metal Shims.....	As Needed

To check/adjust the guide post parallel side-to-side with the blade:

1. DISCONNECT BANDSAW FROM POWER!
2. Tighten the blade to the tension that will be used during operation.
3. Loosen the guide post lock knob, raise the guide post, lock it in place, then place a machinist's square on the table next to the side of the blade as illustrated in **Figure 79**.

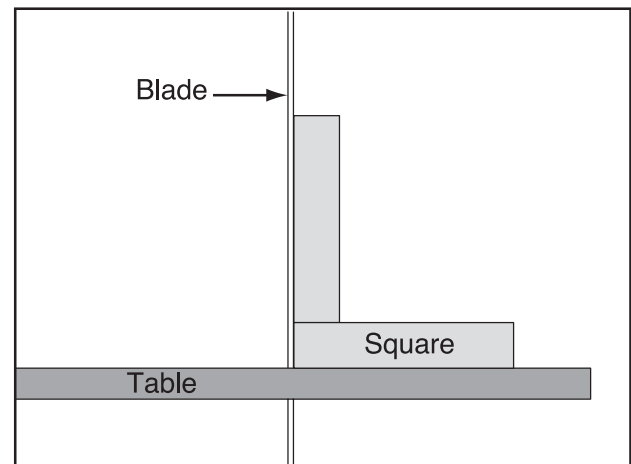


Figure 79. Squaring table to blade.

4. Adjust the table square with the blade using the table tilt handwheel, then secure it with the table tilt lock lever.



5. Loosen the guide post lock knob, lower the guide post to within 1" of the table top, then tighten the knob.
6. Place a machinist's square on the table next to the right hand side of the guide post, as shown in **Figure 80**.

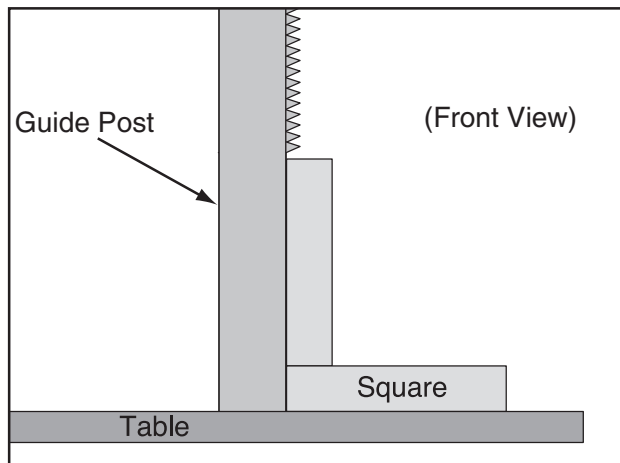


Figure 80. Example of checking guide post squareness.

—If there is no gap between the square and the guide post along its full length, no adjustments need to be made. Proceed to "To check/adjust if the guide post is parallel with the blade front-to-back."

—If there is a gap between the square and the guide post, the guide post is not parallel to the blade. Go to **Step 7**.

7. Loosen each of the four screws shown in **Figure 81** $\frac{1}{4}$ turn.

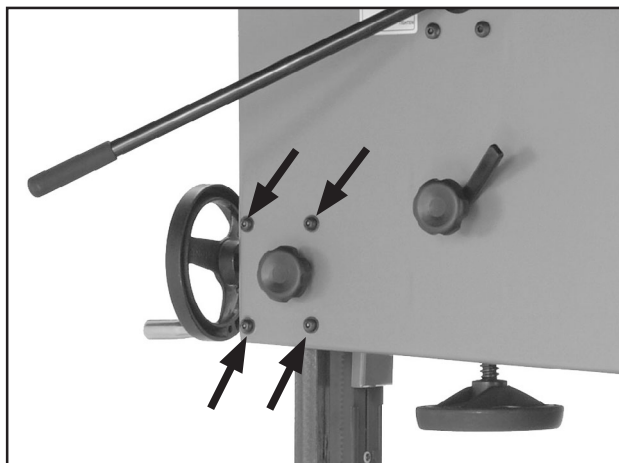


Figure 81. Guide post adjustment screws.

8. Gently tap the lower part of the guide post in the appropriate direction until there is no gap between the square and the guide post.
9. Tighten the screws shown in **Figure 81**.

To check/adjust the guide post parallel with the blade front-to-back:

1. DISCONNECT BANDSAW FROM POWER!
2. Loosen the guide post lock knob, lower the blade guide assembly to within 1" of the table top, then tighten the lock knob.
3. Remove the screws that secure the guide post guard and move it up and out of the way.
4. Measure the distance "A" between the top front face of the guide post rack and the back of the blade (see **Figure 82**).

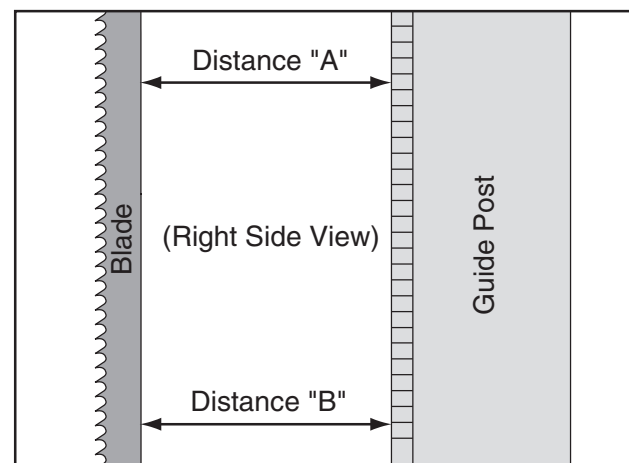


Figure 82. Example of measuring distance between rack and blade at top of guide post.

5. Measure the distance "B" between the bottom front face of the guide post rack and the back of the blade (see **Figure 82**).

—If the measurements taken in **Steps 4–5** are equal, no adjustments need to be made. Go to **Step 9**.

—If the measurements taken in **Steps 4–5** are not equal, go to **Step 6**.



6. Place the guide post guard on top of the guide post assembly so you can access the guide post bracket.

7. Loosen the four screws shown in **Figure 81** enough to fit metal shims between the frame and the guide post bracket (see **Figure 83**).

—If the guide post to blade distance is greater at the bottom than at the top, place a shim between the bottom of the bracket and the frame (Shim "A"). This will tilt the bottom of the guide post toward the blade.

—If the guide post to blade distance is less at the bottom than at the top, place a shim between the top of the bracket and the frame (Shim "B"). This will tilt the bottom of the guide post away from the blade.

8. Tighten the four screws shown in **Figure 81**, then repeat **Steps 4–5**.

—If the measurements are equal, go to **Step 9**.

—If the measurements are not equal, continue adding shims as needed until guide post rack to blade distance is the same at the top and bottom.

9. Reinstall the guide post guard with the screws removed in **Step 3**.

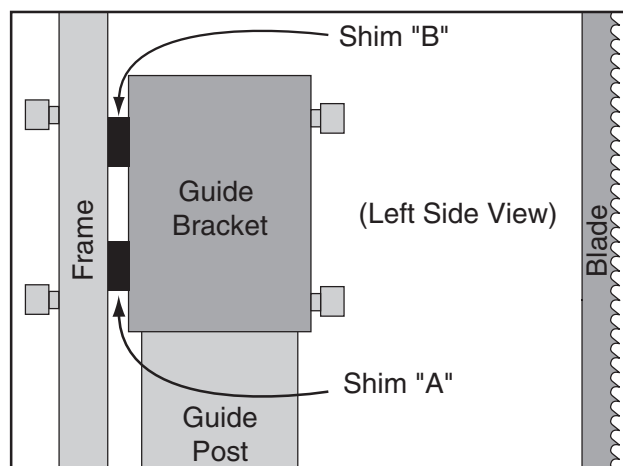


Figure 83. Location for placing shims.



Wheel Alignment

Wheel alignment is one of the most critical factors for optimal performance from your bandsaw.

Heat, vibration, wandering, blade wear, tire wear and overall bandsaw wear are considerably decreased when the wheels are properly aligned or “coplanar.”

Coplanar wheels automatically track the blade by balancing it on the crown of the wheel. This is known as coplanar tracking.

Components and Hardware Needed: Qty
70 $\frac{1}{4}$ " Long Wood 2 x 4..... 1

Tools Needed:

Wrench 17mm..... 1
Tape Measure..... 1
Circular Saw 1
Jointer..... 1

To check if your wheels are coplanar:

1. The body of the bandsaw does not allow you to place a regular straightedge across both wheels at the same time. We’ve found a simple way to overcome this situation. All you need is a 70 $\frac{1}{4}$ " x 2" x 4" board, a jointer and a circular saw. Run the 2" x 4" across a jointer on the side to be placed against the wheels, then cut a 1 $\frac{1}{2}$ " x 28 $\frac{1}{4}$ " notch out of the center. Refer to **Figure 84** for more details on how to make this gauge.
2. After you’ve made your coplanarity gauge, remove the fence and table, then open both wheel covers.
3. Make sure the guide blocks and rear support bearings are away from the blade, then tighten your blade to the tension that it will be used during operation.
4. Place your gauge up against both wheels in the positions shown in **Figure 85**.

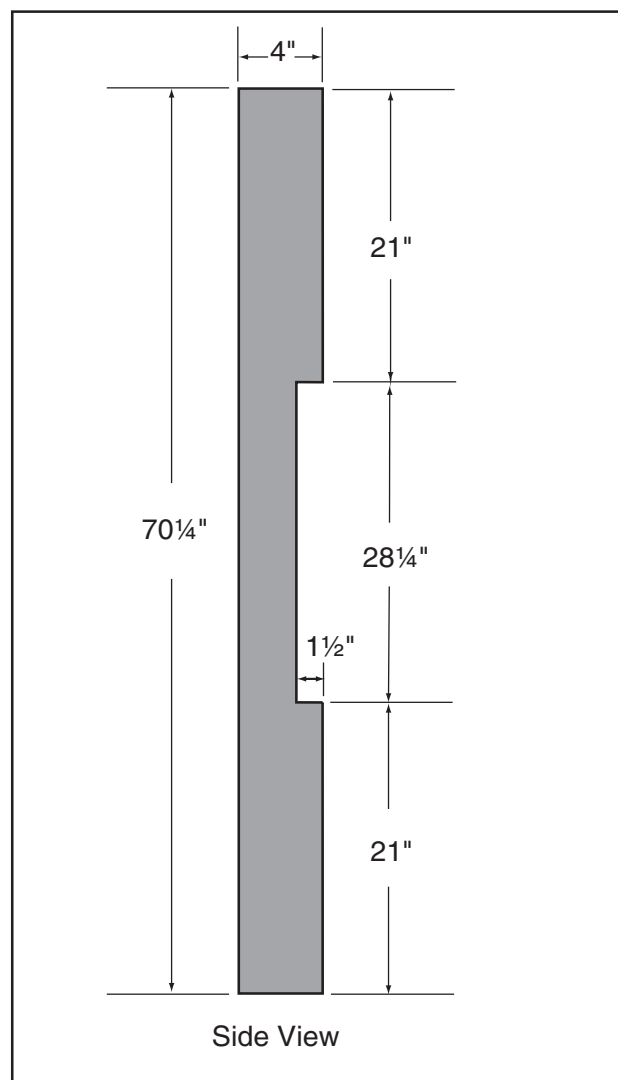


Figure 84. Dimensions of coplanarity gauge.

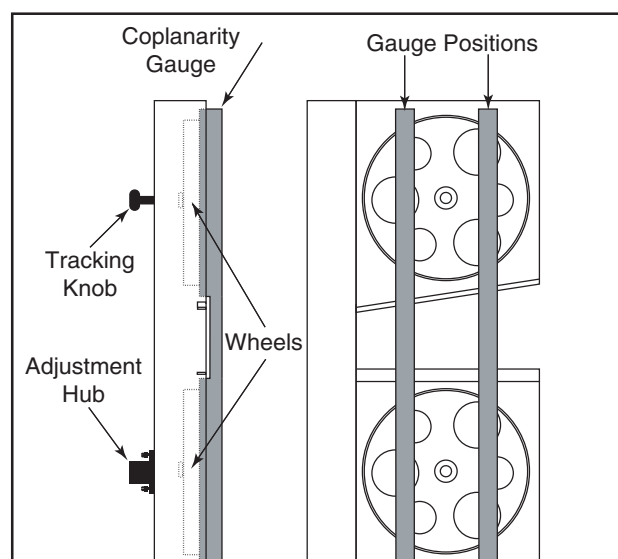


Figure 85. Checking for coplanarity.



5. The adjustment hub allows you to move the lower wheel in the desired direction. Turning all the bolts clockwise in equal amounts pushes the wheel forward. Turning all the bolts counterclockwise brings the wheel backward, closer to the adjustment hub. Used individually, each bolt can control the direction that the wheel tilts.
6. Adjust the tracking knob to get both wheels parallel. If the wheels won't go parallel to each other, then move the lower wheel at the adjustment hub so they line up.
7. If the wheels will go parallel but not coplanar, then move the lower wheel at the adjustment hub (**Figure 86**) as necessary.

8. **Figure 87** shows the positions of the wheels when coplanar. When your wheels are coplanar, readjust the guide blocks and rear support bearings, and replace the wheel covers.

Note: *The blade may track slightly off center when the wheels are coplanar. This is natural because the blade will be balanced on the crown of the tire, rather than just in the center of the tire. This will be more noticeable with larger blades.*

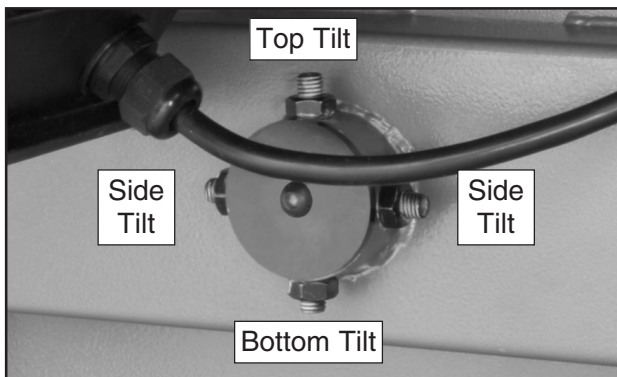


Figure 86. Lower wheel adjustment control.

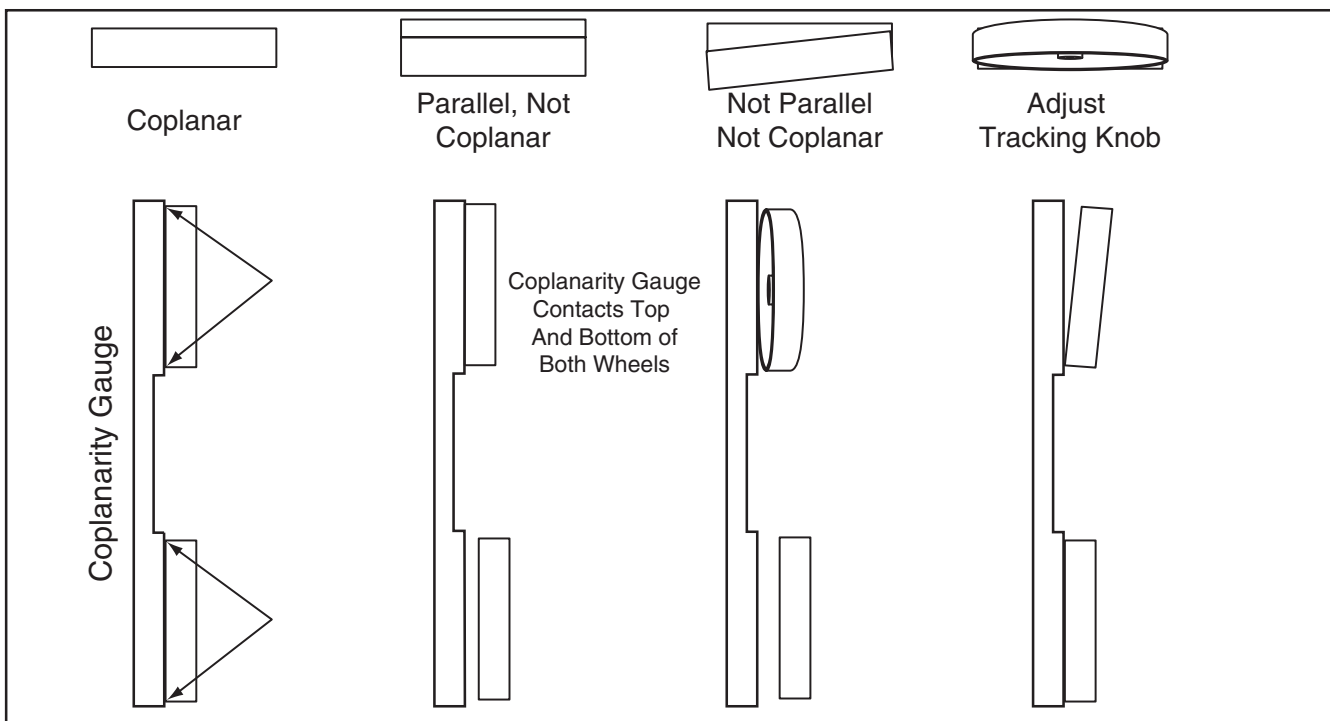


Figure 87. Coplanarity diagram.



SECTION 8: WIRING

These pages are current at the time of printing. However, in the spirit of improvement, we may make changes to the electrical systems of future machines. Study this section carefully. If there are differences between your machine and what is shown in this section, call Technical Support at (570) 546-9663 for assistance BEFORE making any changes to the wiring on your machine.

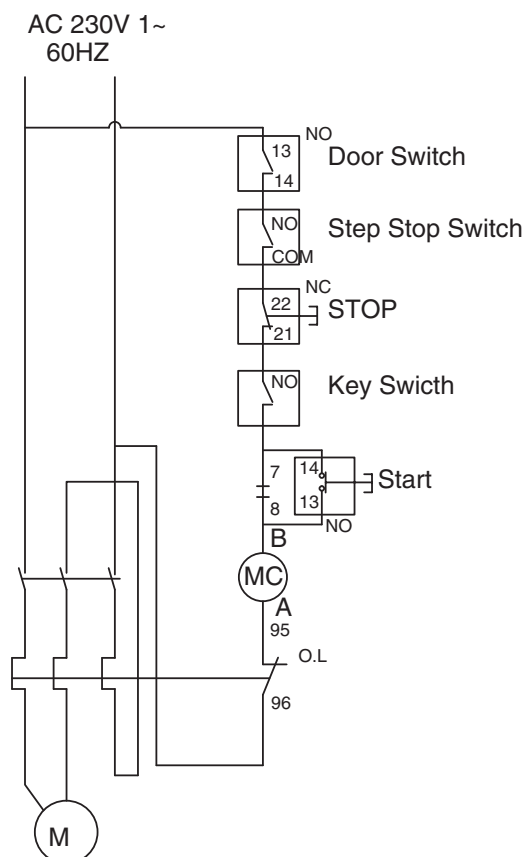
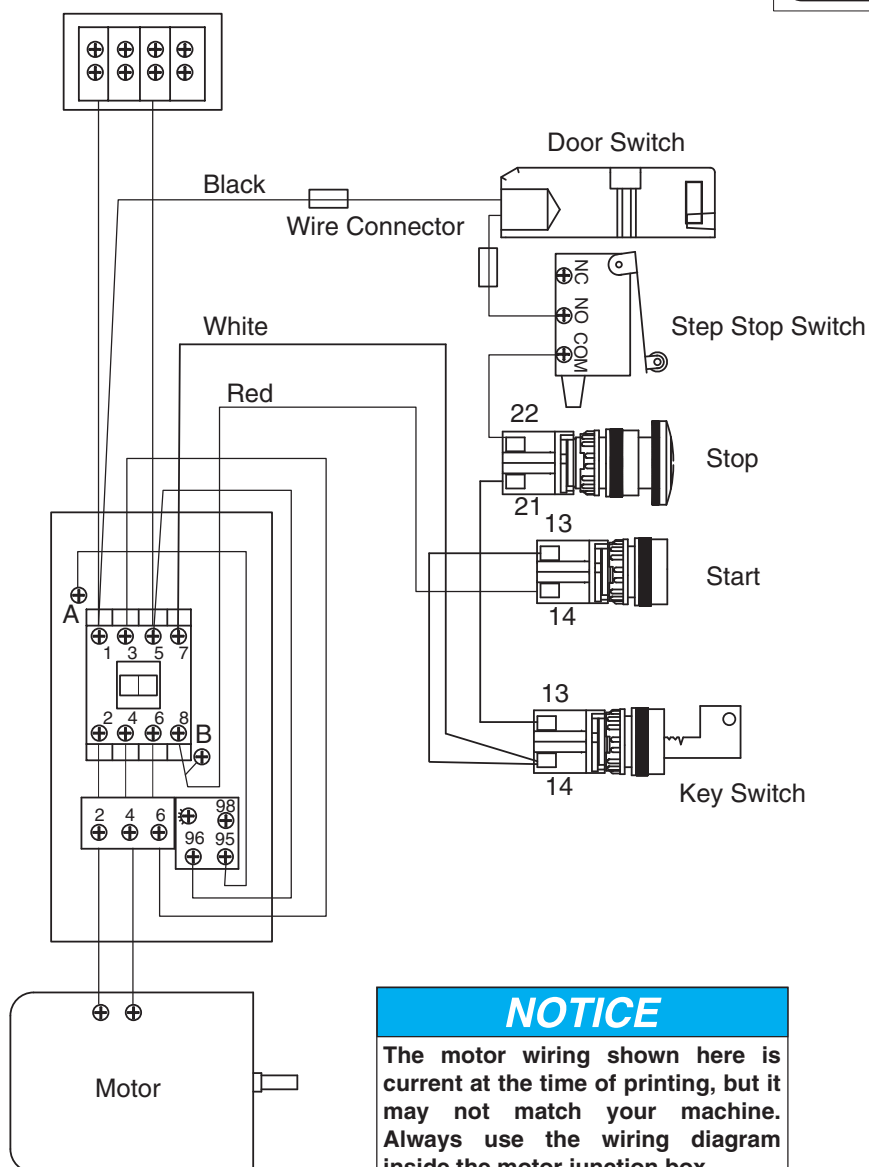
WARNING

Wiring Safety Instructions

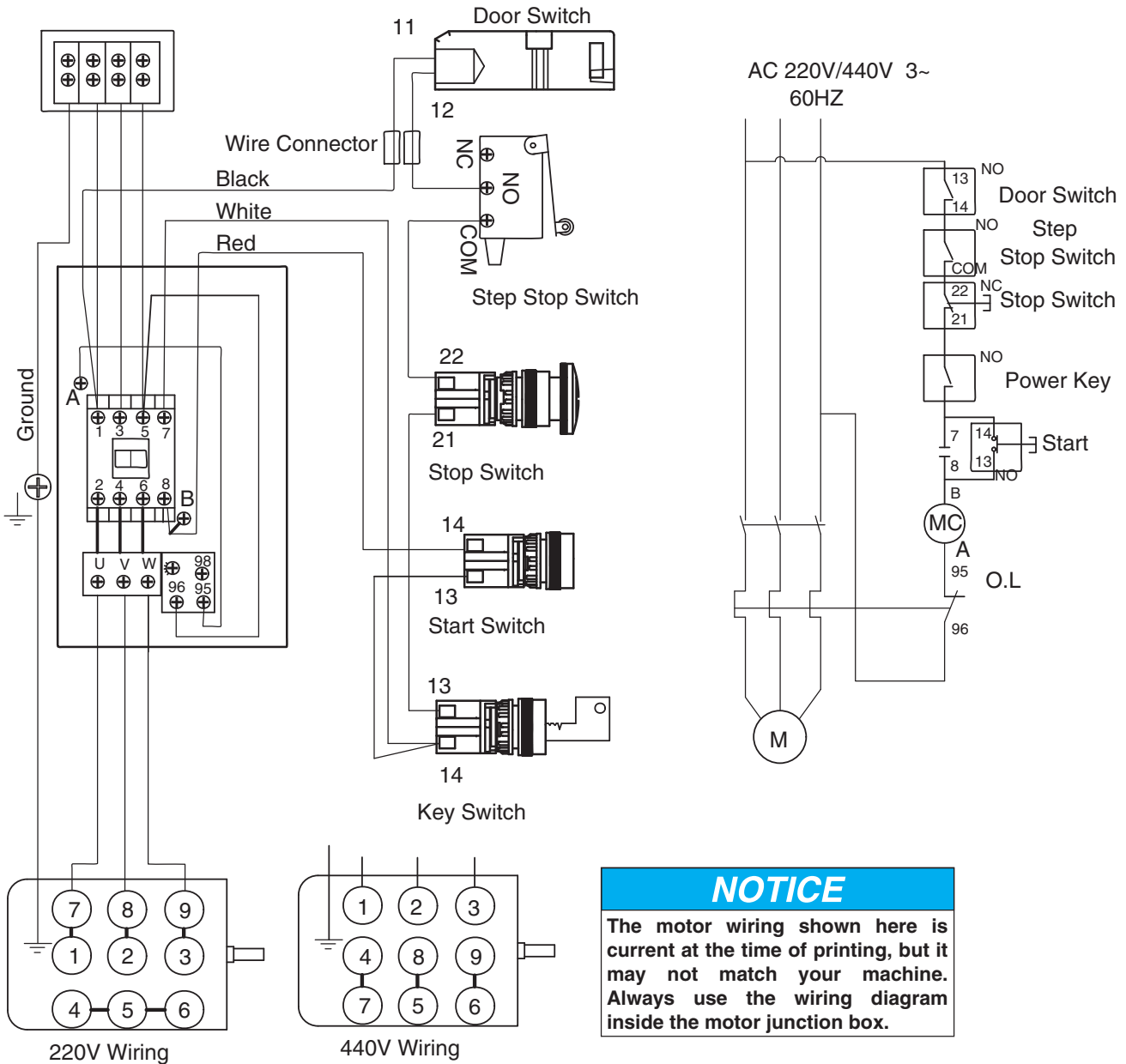
- 1. SHOCK HAZARD.** Working on wiring that is connected to a power source is extremely dangerous. Touching electrified parts will result in personal injury including but not limited to severe burns, electrocution, or death. Disconnect the power from the machine before servicing electrical components!
- 2. QUALIFIED ELECTRICIAN.** Due to the inherent hazards of electricity, only a qualified electrician should perform wiring tasks on this machine. If you are not a qualified electrician, get help from one before attempting any kind of wiring job.
- 3. WIRE CONNECTIONS.** All connections must be tight to prevent wires from loosening during machine operation. Double-check all wires disconnected or connected during any wiring task to ensure tight connections.
- 4. WIRE/COMPONENT DAMAGE.** Damaged wires or components increase the risk of serious personal injury, fire, or machine damage. If you notice that any wires or components are damaged while performing a wiring task, replace those wires or components before completing the task.
- 5. MODIFICATIONS.** Using aftermarket parts or modifying the wiring beyond what is shown in the diagram may lead to unpredictable results, including serious injury or fire.
- 6. MOTOR WIRING.** The motor wiring shown in these diagrams is current at the time of printing, but it may not match your machine. Always use the wiring diagram inside the motor junction box.
- 7. CAPACITORS.** Some capacitors store an electrical charge for up to five minutes after being disconnected from the power source. To avoid being shocked, wait at least this long before working on capacitors.
- 8. CIRCUIT REQUIREMENTS.** You MUST follow the requirements on **Page 11** when connecting your machine to a power source.
- 9. EXPERIENCING DIFFICULTIES.** If you are experiencing difficulties understanding the information included in this section, contact our Technical Support at (570) 546-9663.



Grizzly
Industrial, Inc.®

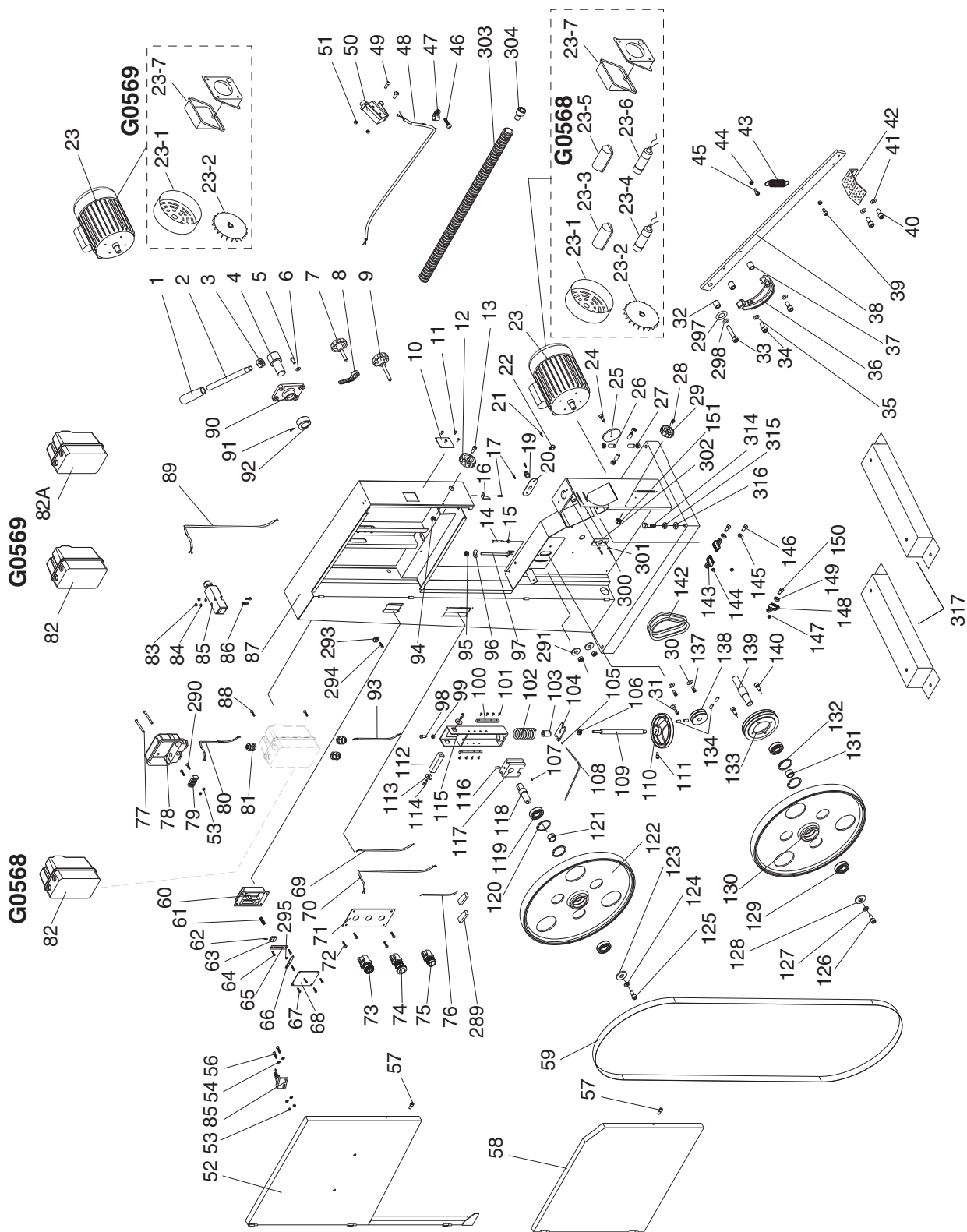


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SECTION 9: PARTS

Main



Main Parts List

REF PART # DESCRIPTION

1	P0566001	HANDLE KNOB M16-1.5
2	P0568002	HANDLE SHAFT
3	PN05M	HEX NUT M16-1.5
4	P0566004	ECCENTRIC SHAFT
5	PSBS03M	BUTTON HD CAP SCR M8-1.25 X 16
6	PLW06M	LOCK WASHER 10MM
7	P0566007	KNOB SCREW M10-1.5 X 25
8	P0566008	LOCK HANDLE M10-1.5
9	P0566009	KNOB SCREW M10-1.5 X 25
10	P0566010	TRANSLUCENT PIECE
11	P0566011	RIVET 3.2 X 10
12	P0566012	LATCHING KNOB 6MM
13	PSB02M	CAP SCREW M6-1 X 20
14	PB73M	HEX BOLT M10-1.5 X 50
15	PN02M	HEX NUT M10-1.5
16	P0566016	HEIGHT POINTER
17	PFS07M	FLANGE SCREW M5-.8 X 10
19	P0566019	STRAIN RELIEF M20
20	P0566020	PLATE
21	PHTEK4M	TAP SCREW M4 X 8
22	P0568022	CORD CLAMP 1/2"
23	P0568023	MOTOR 5HP 220V 1-PHASE (G0568)
23	P0569023	MOTOR 7-1/2HP 220/440V 3PH (G0569)
23-1	P0568023-1	FAN COVER (G0568)
23-1	P0569023-1	FAN COVER (G0569)
23-2	P0568023-2	FAN (G0568)
23-2	P0569023-2	FAN (G0569)
23-3	P0568023-3	CAPACITOR COVER (G0568)
23-4	PC200A	S CAP 200MFD 250V 1-3/8OD X 2-3/4L
23-5	P0568023-5	CAPACITOR COVER (G0568)
23-6	PC20A	R CAP 20MFD 400V 1-5/8OD X 2-3/4L
23-7	P0568023-7	WIRING BOX (G0568)
23-7	P0569023-7	WIRING BOX (G0569)
24	PSBS01M	BUTTON HD CAP SCR M8-1.25 X 20
25	P0566025	COVER
26	PB01M	HEX BOLT M10-1.5 X 30
27	PN02M	HEX NUT M10-1.5
28	PSB02M	CAP SCREW M6-1 X 20
29	P0566029	LATCHING KNOB 6MM
30	PW01M	FLAT WASHER 8MM
31	PSB31M	CAP SCREW M8-1.25 X 25
32	P0566032	BUSHING
33	PSB31M	CAP SCREW M8-1.25 X 25
34	PSB06M	CAP SCREW M6-1 X 25
35	PLW02M	LOCK WASHER 4MM
36	P0636X036	BRAKE PAD
37	P0566037	BUSHING
38	P0568038	BRAKE LEVER
39	PSB01M	CAP SCREW M6-1 X 16
40	PSB01M	CAP SCREW M6-1 X 16
41	PLW03M	LOCK WASHER 6MM
42	P0566042	BRAKE STEP PLATE
43	P0566043	SPRING 1.6 X 40 X 63
44	PN01M	HEX NUT M6-1
45	PSB01M	CAP SCREW M6-1 X 16

REF PART # DESCRIPTION

46	PHTEK4M	TAP SCREW M4 X 8
47	P0566047	CORD CLAMP 5/8
48	P0566048	STEP CORD
49	PB41M	HEX BOLT M4-.7 X 30
50	P0566050	LIMIT SWITCH KL7141
51	PN04M	HEX NUT M4-.7
52	P0568052	UPPER WHEEL COVER
53	PN04M	HEX NUT M4-.7
54	PW05M	FLAT WASHER 4MM
56	PS38M	PHLP HD SCR M4-.7 X 10
57	PS68M	PHLP HD SCR M6-1 X 10
58	P0568058	LOWER WHEEL COVER
59	P0568059	SAW BLADE 181" X 1" X .035"
60	P0566060	UPPER WHEEL SLIDING BRACKET
61	P0566061	SPRING 1 X 8 X 40
62	PRP61M	ROLL PIN 3 X 12
63	P0566063	MOVING PLATE
64	PHTEK15M	TAP SCREW M4 X 10
65	P0566065	FIX PLATE
66	P0566066	TENSION POINTER
67	PHTEK6M	TAP SCREW M4 X 16
68	P0568068	TENSION SCALE
69	P0566069	CONNECTING CORD
70	P0566070	SWITCH CORD
71	P0566071	SWITCH PLATE
72	PHTEK15M	TAP SCREW M4 X 10
73	P0566073	KEY SWITCH 22
74	P0566074	STOP SWITCH 22
75	P0566075	START SWITCH 22
76	P0566076	CONNECTING CORD
77	PFS09M	FLANGE SCREW M5-.8 X 50
78	P0568078	TERMINAL BOX
79	P0568079	TERMINAL HOUSE
80	P0568080	POWER CORD
81	P0568081	STRAIN RELIEF M20
82	P0568082	MAG SWITCH MPE-18 220-240V 5HP
82	P0569082	MAG SWITCH 220V 20A (G0569)
82A	P0569082A	MAG SWITCH 440V 12A (G0569)
83	PN04M	HEX NUT M4-.7
84	PW05M	FLAT WASHER 4MM
85	P0566085	DOOR LATCH SWITCH ADZ-S11
86	PFS10M	FLANGE SCREW M4-.7 X 35
87	P0568087	MACHINE BODY
88	PFS07M	FLANGE SCREW M5-.8 X 10
89	P0566089	SWITCH CORD
90	P0566090	HOUSING PLATE
91	PSB31M	CAP SCREW M8-1.25 X 25
92	P0566092	CAM
93	P0566093	MOTOR CORD
94	PLN03M	LOCK NUT M6-1
95	PN02M	HEX NUT M10-1.5
96	PW04M	FLAT WASHER 10MM
97	PSB14M	ADJUST BOLT
98	PB26M	HEX BOLT M8-1.25 X 30
99	PN03M	HEX NUT M8-1.25



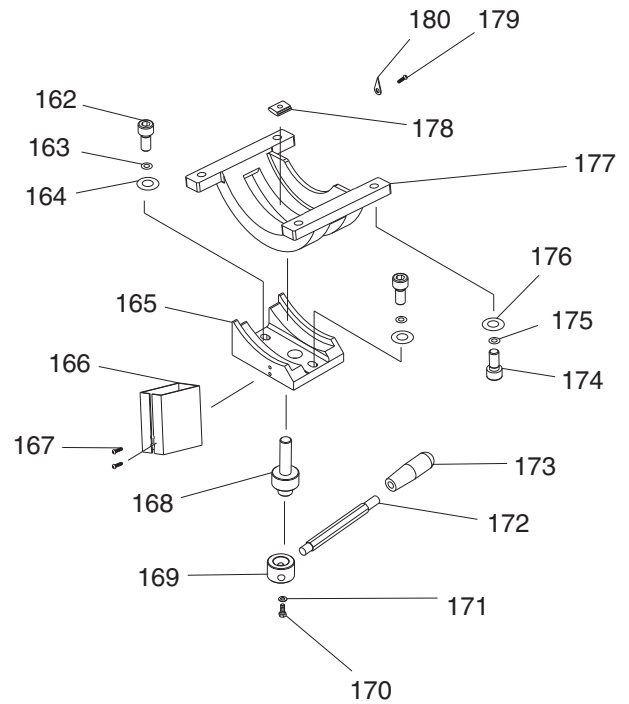
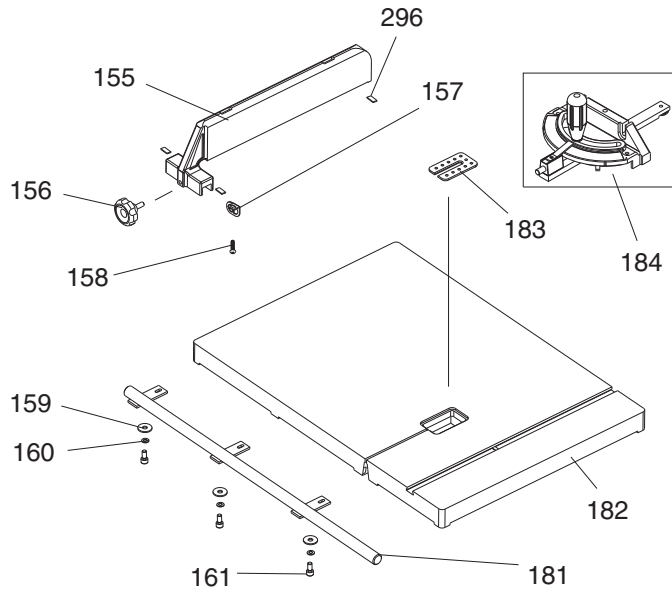
Main Parts List Continued

REF	PART #	DESCRIPTION
100	P0566100	LOCATE PLATE
101	PFH39M	FLAT HD SCR M5-.8 X 16
102	P0568102	SPRING 12 X 4 X 70
103	P0566103	BUSHING
104	P0566104	PRESS BLOCK
105	PSS07M	SET SCREW M5-.8 X 5
106	P51201	THRUST BEARING 51201
107	PSS07M	SET SCREW M5-.8 X 5
108	P0566108	TENSION LINE
109	P0568109	SPECIAL BOLT
110	P0566110	HANDWHEEL
111	PSB06M	CAP SCREW M6-1 X 25
112	P0566112	SQUARE SHAFT
113	PW01M	FLAT WASHER 8MM
114	PSB31M	CAP SCREW M8-1.25 X 25
115	P0566115	UPPER WHEEL HINGE ASSY
116	PSS75M	SET SCREW M10-1.5 X 16
117	P0566117	GUIDE BLOCK
118	P0568118	UPPER WHEEL SHAFT
119	P6306	BALL BEARING 6306ZZ
120	PR64M	INT RETAINING RING 72MM
121	P0568121	BUSHING
122	P0568122	UPPER WHEEL 25"
123	PW01M	FLAT WASHER 8MM
124	PLW04M	LOCK WASHER 8MM
125	PSB14M	CAP SCREW M8-1.25 X 20
126	PSB14M	CAP SCREW M8-1.25 X 20
127	PLW04M	LOCK WASHER 8MM
128	PW01M	FLAT WASHER 8MM
129	P6306	BALL BEARING 6306ZZ
130	P0568130	LOWER WHEEL 25"
131	P0568131	BUSHING
132	PR64M	INT RETAINING RING 72MM

REF	PART #	DESCRIPTION
133	P0566133	PULLEY
134	PSS20M	SET SCREW M8-1.25 X 8
137	PSB14M	CAP SCREW M8-1.25 X 20
138	P0566138	PULLEY
139	P0568139	LOWER SHAFT
140	PSBS01M	BUTTON HD CAP SCR M8-1.25 X 20
142	PVA33	V-BELT 4L330
143	P0513058	BRUSH
144	PLN03M	LOCK NUT M6-1
145	PW03M	FLAT WASHER 6MM
146	PSB02M	CAP SCREW M6-1 X 20
147	PLN03M	LOCK NUT M6-1
148	PW01M	FLAT WASHER 8MM
149	PW03M	FLAT WASHER 6MM
150	PSB02M	CAP SCREW M6-1 X 20
151	PLN03M	LOCK NUT M6-1
289	P0568289	CORD CONNECTOR 224-201
290	PS52M	PHLP HD SCR M4-.7 X 20
291	PW01M	FLAT WASHER 8MM
293	P0568293	CORD CLAMP 5/16"
294	PHTEK15M	TAP SCREW M4 X 10
295	PW01M	FLAT WASHER 8MM
297	PW01M	FLAT WASHER 8MM
298	PLW04M	LOCK WASHER 8MM
300	PFS11M	FLANGE SCREW M6-1 X 10
301	PW03M	FLAT WASHER 6MM
302	P0568302	SUPPORT
303	P0568303	PROTECT TUBE 1/2" X 1100MM(L)
304	P0568304	CORD BUSHING
314	PB76M	HEX BOLT M12-1.75 X 110
315	PLW05M	LOCK WASHER 12MM
316	PW06M	FLAT WASHER 12MM
317	P0568317	RISER BAR



Table

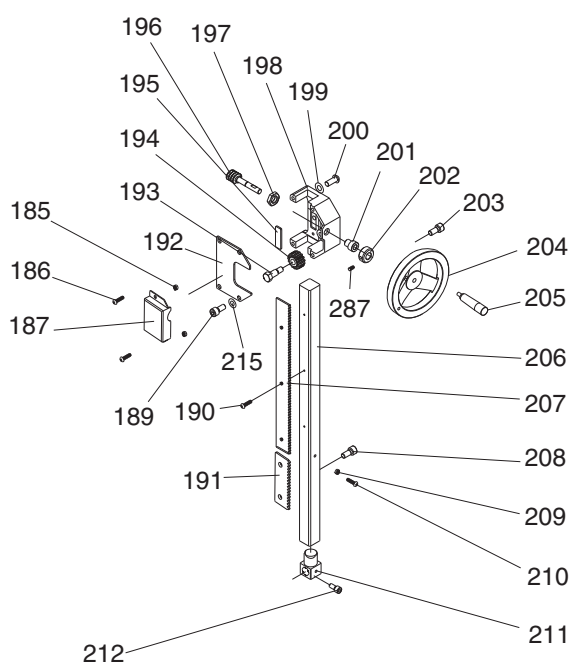


REF	PART #	DESCRIPTION
155	P0566155	FENCE
156	P0566156	KNOB SCREW M10-1.5 X 25
157	P0566157	POINTER
158	PFS01M	FLANGE SCREW M5-.8 X 8
159	PW03M	FLAT WASHER 6MM
160	PLW02M	LOCK WASHER 4MM
161	PSB14M	CAP SCREW M8-1.25 X 20
162	PSB72M	CAP SCREW M10-1.5 X 30
163	PLW06M	LOCK WASHER 10MM
164	PW04M	FLAT WASHER 10MM
165	P0566165	TRUNNION HOUSING
166	P0566166	BLADE GUARD
167	PFS11M	FLANGE SCREW M6-1 X 10
168	P0566168	PRESS SHAFT
169	P0566169	MICRO ADJUSTING RING
170	PSB14M	CAP SCREW M8-1.25 X 20

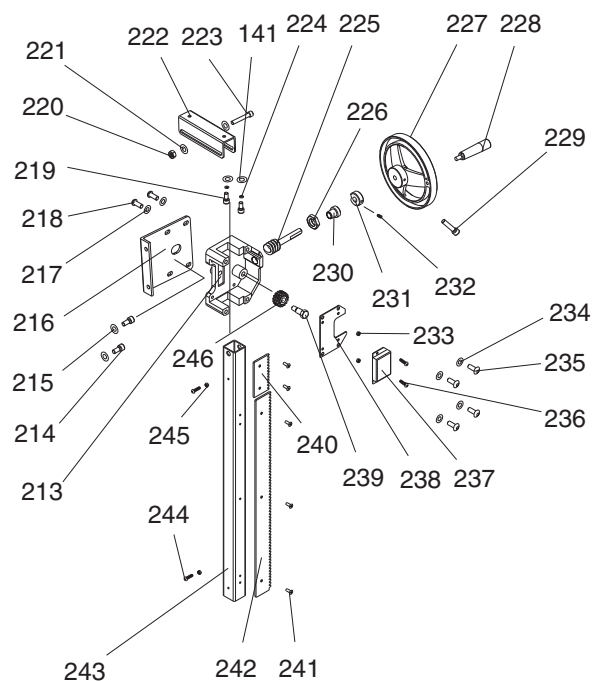
REF	PART #	DESCRIPTION
171	PLW04M	LOCK WASHER 8MM
172	P0566172	HANDLE SHAFT
173	P0566173	HANDLE KNOB M12-1.75 (FEMALE)
174	PSB84M	CAP SCREW M10-1.5 X 35
175	PLW06M	LOCK WASHER 10MM
176	PW04M	FLAT WASHER 10MM
177	P0566177	TRUNNION BLOCK
178	P0566178	PRESS BLOCK
179	PS38M	PHLP HD SCR M4-.7 X 10
180	P0566180	POINTER
181	P0568181	GUARD RAIL
182	P0568182	TABLE
183	P0566183	TABLE INSERT
184	P0566184	MITER GAUGE ASSY
296	P0568296	NYLON PIECE



Guide Post



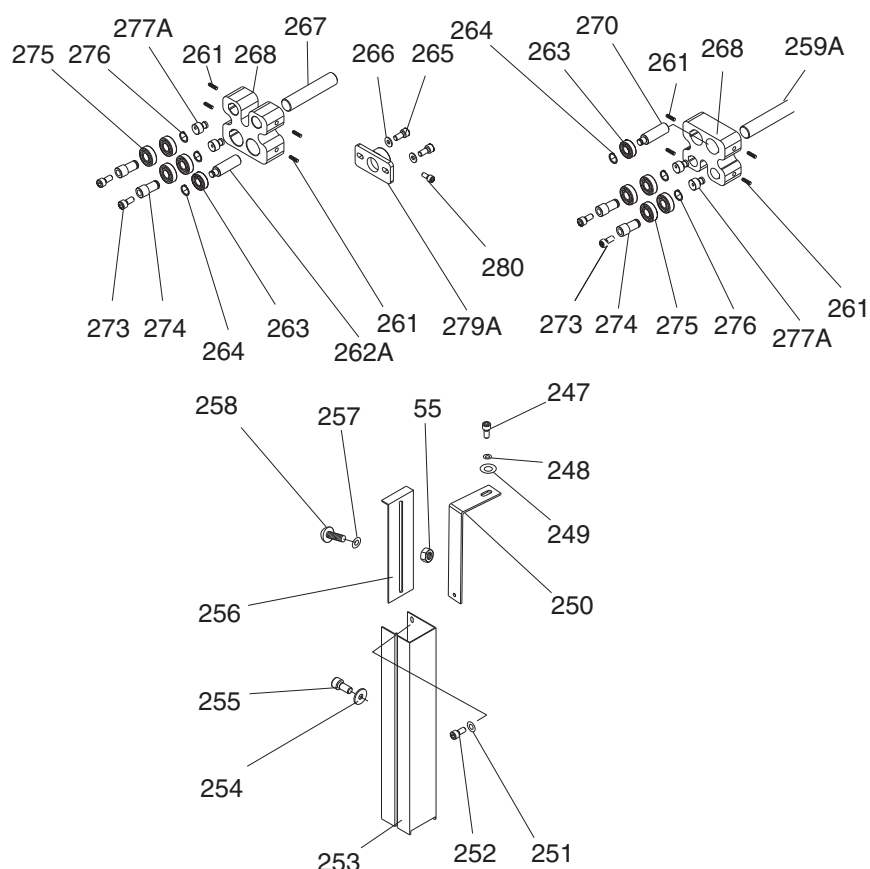
REF	PART #	DESCRIPTION
141	PW03M	FLAT WASHER 6MM
185	PLW04M	LOCK WASHER 8MM
186	PFS07M	FLANGE SCREW M5-.8 X 10
187	P0566187	COVER
189	PSB11M	CAP SCREW M8-1.25 X 16
190	PFH19M	FLAT HD SCR M4-.7 X 10
191	P0566191	EXTENSION RACK
192	P0566192	COVER
193	P0566193	FIXED BOLT
194	P0566194	PINION GEAR
195	P0566195	FIXED PLATE
196	P0566196	WORM CYLINDER
197	PN05M	HEX NUT M16-1.5
198	P0566198	GUIDE BRACKET
199	PW01M	FLAT WASHER 8MM
200	PSBS04M	BUTTON HD CAP SCR M8-1.25 X 35
201	P0566201	BUSHING
202	P0566202	SWITCH BUSHING
203	PSB06M	CAP SCREW M6-1 X 25
204	P0568204	HANDWHEEL
205	P0568205	HANDLE
206	P0568206	UPPER GUIDE SUPPORT BLOCK
207	P0566207	RACK
208	PSB01M	CAP SCREW M6-1 X 16
209	PN04M	HEX NUT M4-.7
210	PS38M	PHLP HD SCR M4-.7 X 10
211	P0568211	UPPER GUIDE SUPPORT BLOCK
212	PB83M	HEX BOLT M6-1 X 16
213	P0566213	GUIDE BRACKET
214	PSB14M	CAP SCREW M8-1.25 X 20
215	PLW04M	LOCK WASHER 8MM
216	P0566216	SUPPORT PLATE



REF	PART #	DESCRIPTION
217	PW01M	FLAT WASHER 8MM
218	PSBS01M	BUTTON HD CAP SCR M8-1.25 X 20
219	PB04M	HEX BOLT M6-1 X 10
220	PLN04M	LOCK NUT M8-1.25
221	PLW04M	LOCK WASHER 8MM
222	P0566222	SLIDING PLATE
223	PB30M	HEX BOLT M8-1.25 X 55
224	PLW03M	LOCK WASHER 6MM
225	P0566225	WORM CYLINDER
226	PN05M	HEX NUT M16-1.5
227	P0566227	HANDWHEEL
228	PS52M	PHLP HD SCR M4-.7 X 20
229	PSB06M	CAP SCREW M6-1 X 25
230	P0566230	BUSHING
231	P0566231	SWITCH BUSHING
232	PSS07M	SET SCREW M5-.8 X 5
233	PN03M	HEX NUT M8-1.25
234	PLW04M	LOCK WASHER 8MM
235	PSB11M	CAP SCREW M8-1.25 X 16
236	PFS07M	FLANGE SCREW M5-.8 X 10
237	P0568237	COVER
238	P0568238	COVER
239	P0568239	SPECIAL BOLT
240	P0568240	STRETCH RACK
241	PFH19M	FLAT HD SCR M4-.7 X 10
242	P0566242	RACK
243	P0568243	SQUARE TUBE
244	PS38M	PHLP HD SCR M4-.7 X 10
245	PN04M	HEX NUT M4-.7
246	P0568246	PINION GEAR 15T
287	PSS07M	SET SCREW M5-.8 X 5



Blade Guides

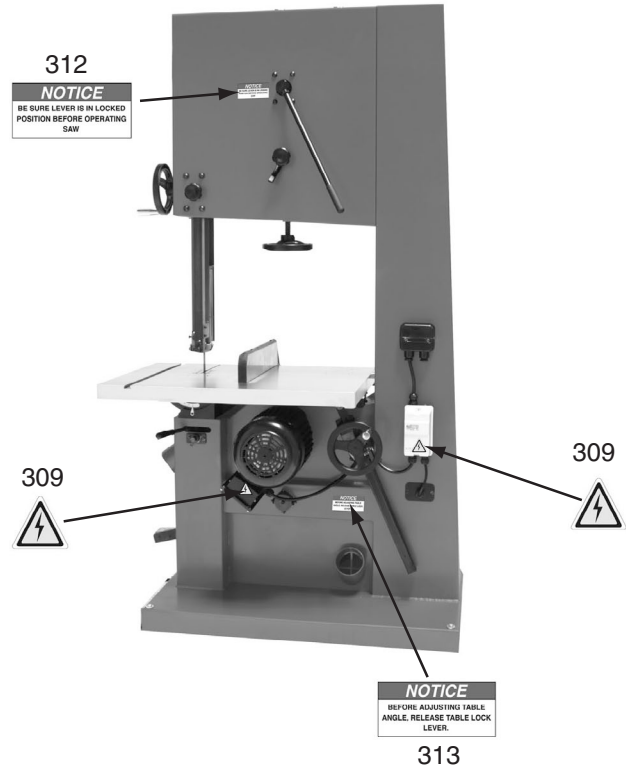
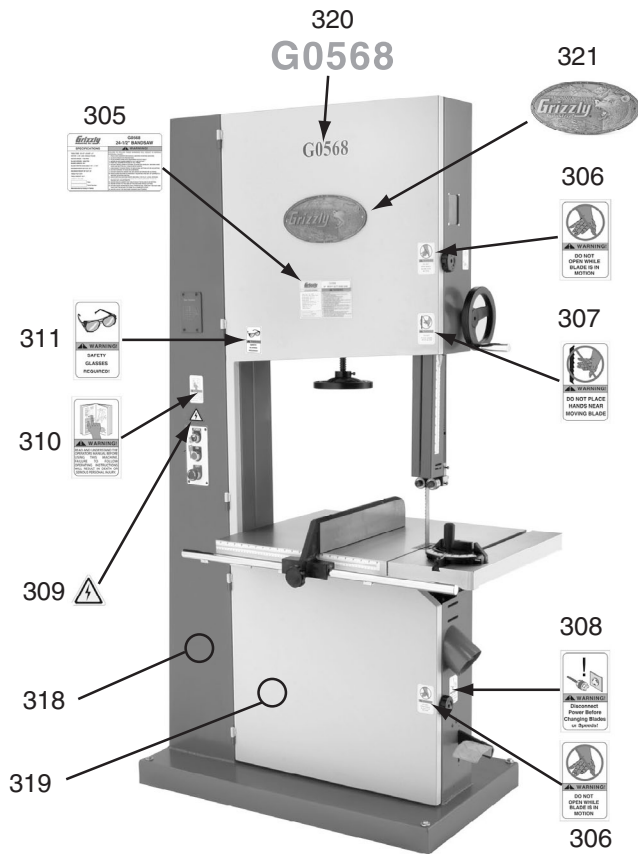


REF	PART #	DESCRIPTION
55	PN01M	HEX NUT M6-1
247	PSB04M	CAP SCREW M6-1 X 10
248	PLW03M	LOCK WASHER 6MM
249	PW03M	FLAT WASHER 6MM
250	P0566250	SUPPORT PLATE
251	PW03M	FLAT WASHER 6MM
252	PSB04M	CAP SCREW M6-1 X 10
253	P0568253	PROTECT COVER
254	PW03M	FLAT WASHER 6MM
255	PSB04M	CAP SCREW M6-1 X 10
256	P0568256	SLIDING PLATE
257	P0568257	PLASTIC WASHER 6MM
258	PS68M	PHLP HD SCR M6-1 X 10
259A	P0566259A	ADJUST BAR V2.10.05 (ROUND)
261	PSS01M	SET SCREW M6-1 X 10

REF	PART #	DESCRIPTION
262A	P0566262A	UPPER SPACING SLEEVE V2.12
263	P6201	BALL BEARING 6201ZZ
264	PR03M	EXT RETAINING RING 12MM
265	PSB01M	CAP SCREW M6-1 X 16
266	PW03M	FLAT WASHER 6MM
267	P0566267	ADJUSTING SHAFT
268	P0566268	BLADE GUIDE SUPPORT
270	P0566270	UPPER SPACING SLEEVE
273	PB47M	HEX BOLT M6-1 X 40
274	P0568274	HANDLE BUSHING
275	P6202ZZ	BALL BEARING 6202ZZ
276	PR05M	EXT RETAINING RING 15MM
277A	P0566277A	ECCENTRIC SHAFT V2.12.05
279A	P0566279A	SUPPORT BRACKET V2.09.06
280	PS83M	HEX BOLT M6-1 X 16



Label Placement



REF	PART #	DESCRIPTION
305	P0568305	MACHINE ID LABEL G0568
305	P0569305	MACHINE ID LABEL G0569
306	PLABEL-20	DONT OPEN 2W X 3.3H
307	PLABEL-19	BANDSAW BLADE 2W X 3.3H
308	PLABEL-18	UNPLUG BANDSAW 2W X 3.3H
309	PLABEL-14	ELECTRICITY 1.4W X 1.2H
310	PLABEL-12	READ MANUAL 2W X 3.3H
311	PLABEL-11	SAFETY GLASSES 2W X 3.3H

REF	PART #	DESCRIPTION
312	P0566300	TENSION LEVER LABEL
313	P0566301	TABLE LOCK LABEL
318	PPAINT-1	GRIZZLY GREEN TOUCH UP PAINT
319	PPAINT-10	LIGHT GRAY REF PAINT
320	P0568320	MODEL # LABEL
320	P0569320	MODEL # LABEL
321	G8589	GRIZZLY LOGO PLATE

⚠ WARNING

Safety labels warn about machine hazards and ways to prevent injury. The owner of this machine **MUST** maintain the original location and readability of the labels on the machine. If any label is removed or becomes unreadable, **REPLACE** that label before using the machine again. Contact Grizzly at (800) 523-4777 or www.grizzly.com to order new labels.





WARRANTY CARD

Name _____
Street _____
City _____ State _____ Zip _____
Phone # _____ Email _____ Invoice # _____
Model # _____ Order # _____ Serial # _____

*The following information is given on a voluntary basis. It will be used for marketing purposes to help us develop better products and services. **Of course, all information is strictly confidential.***

1. How did you learn about us?

_____ Advertisement _____ Friend _____ Catalog
_____ Card Deck _____ Website _____ Other: _____

2. Which of the following magazines do you subscribe to?

_____ Cabinet Maker	_____ Popular Mechanics	_____ Today's Homeowner
_____ Family Handyman	_____ Popular Science	_____ Wood
_____ Hand Loader	_____ Popular Woodworking	_____ Wooden Boat
_____ Handy	_____ Practical Homeowner	_____ Woodshop News
_____ Home Shop Machinist	_____ Precision Shooter	_____ Woodsmith
_____ Journal of Light Cont.	_____ Projects in Metal	_____ Woodwork
_____ Live Steam	_____ RC Modeler	_____ Woodworker West
_____ Model Airplane News	_____ Rifle	_____ Woodworker's Journal
_____ Modeltec	_____ Shop Notes	_____ Other: _____
_____ Old House Journal	_____ Shotgun News	

3. What is your annual household income?

_____ \$20,000-\$29,000 _____ \$30,000-\$39,000 _____ \$40,000-\$49,000
_____ \$50,000-\$59,000 _____ \$60,000-\$69,000 _____ \$70,000+

4. What is your age group?

_____ 20-29 _____ 30-39 _____ 40-49
_____ 50-59 _____ 60-69 _____ 70+

5. How long have you been a woodworker/metalworker?

_____ 0-2 Years _____ 2-8 Years _____ 8-20 Years _____ 20+ Years

6. How many of your machines or tools are Grizzly?

_____ 0-2 _____ 3-5 _____ 6-9 _____ 10+

7. Do you think your machine represents a good value?

_____ Yes _____ No

8. Would you recommend Grizzly Industrial to a friend?

_____ Yes _____ No

9. Would you allow us to use your name as a reference for Grizzly customers in your area?

Note: We never use names more than 3 times.

_____ Yes _____ No

10. Comments: _____

CUT ALONG DOTTED LINE

FOLD ALONG DOTTED LINE



Place
Stamp
Here



GRIZZLY INDUSTRIAL, INC.
P.O. BOX 2069
BELLINGHAM, WA 98227-2069



FOLD ALONG DOTTED LINE

Send a Grizzly Catalog to a friend:

Name _____
Street _____
City _____ State _____ Zip _____

TAPE ALONG EDGES--PLEASE DO NOT STAPLE

WARRANTY AND RETURNS

Grizzly Industrial, Inc. warrants every product it sells for a period of **1 year** to the original purchaser from the date of purchase. This warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence, accidents, repairs or alterations or lack of maintenance. This is Grizzly's sole written warranty and any and all warranties that may be implied by law, including any merchantability or fitness, for any particular purpose, are hereby limited to the duration of this written warranty. We do not warrant or represent that the merchandise complies with the provisions of any law or acts unless the manufacturer so warrants. In no event shall Grizzly's liability under this warranty exceed the purchase price paid for the product and any legal actions brought against Grizzly shall be tried in the State of Washington, County of Whatcom.

We shall in no event be liable for death, injuries to persons or property or for incidental, contingent, special, or consequential damages arising from the use of our products.

To take advantage of this warranty, contact us by mail or phone and give us all the details. We will then issue you a "Return Number," which must be clearly posted on the outside as well as the inside of the carton. We will not accept any item back without this number. Proof of purchase must accompany the merchandise.

The manufacturers reserve the right to change specifications at any time because they constantly strive to achieve better quality equipment. We make every effort to ensure that our products meet high quality and durability standards and we hope you never need to use this warranty.

Please feel free to write or call us if you have any questions about the machine or the manual.

Thank you again for your business and continued support. We hope to serve you again soon.

grizzly.com[®]

TOOL WEBSITE

Buy Direct and Save with Grizzly[®] – Trusted, Proven and a Great Value!
~Since 1983~

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Current Specials!*

**ORDER
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